

Date: Thursday, 3/8/2007 1:18:46 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number	: 31122		
Estimate Number	: 10799		
P.O. Number	: <i>N/A</i>	Part Number	: D350600142
This Issue	: 3/8/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3188/ICA
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31121	Drawing Revision	: C
		Material	: <i>N/A</i>
		Due Date	: 4/15/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	:		
Comment	:		

Est Rev:D 05.04.14 Incorporated procedures from D3187-1/-2 K  
 J/JLM  
 Est Rev:E 06-11-20 As per DSI9335 JLM  
 est rev F 07.02.07 iin rev.c ec

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

2.0	31122A	SWITCH RELOCATION KIT
-----	--------	-----------------------



Comment: Sub-Component SWITCH RELOCATION KIT

3.0	<del>31122B</del> w/o 30090	SPACEPOD BODY RH
-----	-----------------------------	------------------



Comment: Sub-Component SPACEPOD BODY RH

D3188-2M Batch: B 30090

4.0	<del>OK 31122C</del> w/o 31122C ml	SPACEPOD DOOR RH
-----	------------------------------------	------------------



Comment: Sub-Component SPACEPOD DOOR LH

D3186-2 B 31122C

5.0	D31872	Spacepod Floor
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1	D3187-2	Floor	<u>B31836</u>
1	D3186-2	Door (ref)	<u>31122C</u>
1	D3188-2M	Body(ref)	<u>30090</u>

→ in store already painted

ml 07/08/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

28 ALS4-1032-130

Insert

M103495

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-2 into D3188-2.

N/A — Used jig DT 8971 for R/H

2-Open holes in D3188-2 body floor to Ø0.297".

3-Install inserts in D3188-2 as per Dwg D3188.

4-Open holes in D3187-2 aluminum floor to 0.250" per dwg D3187

N/A floor D3187-2 is already painted.

5-Deburr holes in D3187-2

N/A

ml 07/08/16

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/16

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

\*\*\*\*\*D3187-2 floor only\*\*\*\*\*

Chemical Conversion Coat as per QSI 005 4.1

N/A

ml 07/08/15

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*\*\*D3187-2 floor only\*\*\*\*\*

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A

ml 07/08/15

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

ml 07/08/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:18:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

ml 07/08/15

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

5.62SF D2986

Neoprene Foam

B30632

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T2

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M102565

ml 07/08/16

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/08/16

16.0

ALS41032130

Insert



Washer x8  
A3235020935



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Insert

batch:

B3 M104760

17.0

D35671

D3567-2

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DECAL

batch:

B31128

18.0

MS20426AD45

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Batch:

M3459

ml 07/08/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:18:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35491

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B31125

20.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Batch: B31692

21.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210

22.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Batch: M104156

23.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Batch: B33423

24.0

MS20426AD46

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivet

Batch: M100151

25.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B33968 x2

✓ m/07/09/11  
07/18/150

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B30630

27.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M19216

28.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104537

29.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M104812

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-2 floor with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for body & floor\*\*\*

n/a

ml

31.0

D35529

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30673

32.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585

CPD 07/18/150

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD8

Washer



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104537-

34.0

NAS1515H3

Washer



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100993-

35.0

MS21042L08

Nut



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M104812-

36.0

D2464

3/4 Seal



*CP*



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B30681-

37.0

D35671 D3567-2

DECAL



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B31128

38.0

D2586

Door Latch



*CP*



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Door Latch

batch: B32504-

39.0

D2585

Latch Clamp



*CP*



Comment: Qty.: 3 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Latch Clamp

batch: B33487-

2 to 3  
3

*CP* 7/08/150

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:18:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Latch Plate

batch: B28916

41.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Screw

batch: M105108

42.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

batch: M104885

43.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

batch: M104936

44.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B31832

45.0

D2228

Backing Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Backing Plate

batch: B30679

46.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104603

*CP 07/08/150*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:18:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD8

Washer



*CP*



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

*M104537-*

48.0

MS21042L08

Nut



*CP*



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch:

*M104812-*

49.0

D28572

Hinge Bracket



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch:

*B30718-*

50.0

D35481

BRACKET



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch:

*B30245-*

51.0

D35547

BALL STUD



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch:

*B30210-*

52.0

AN960JD516

Washer



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch:

*M104156-*

53.0

D30153

Lock Nut



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch:

*B33423*

*CP 07/08/150*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 3/8/2007 1:18:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

*ml 07/09/11*

*x1*

55.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Er 02/09/13*

56.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: *M105386*

*ml 07 09 14*

*(1)*

57.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

*mm*

*07-09-14*

58.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

*B31805*

1 D3187-1(Ref)

Spacepod Floor

*31122 31836*

*CP 07/07/17 @*

59.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*Er 02/09/17*

60.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142

Location:

PPP Rev: *D*

*CP 07/09/17 @*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PL Date: 07/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:18:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31122

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 17071891/9 (1)

Job Completion



Handwritten: U 07-09-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

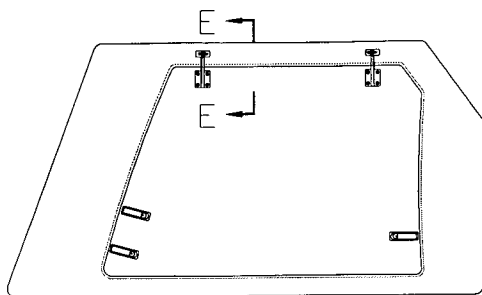


FIGURE 3. LOOKING AT OUTSIDE OF  
D350-600-145 DOOR  
(D350-600-146 SIMILAR AND OPPOSITE)

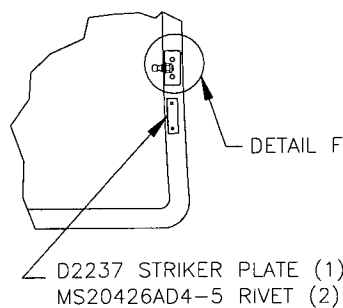


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

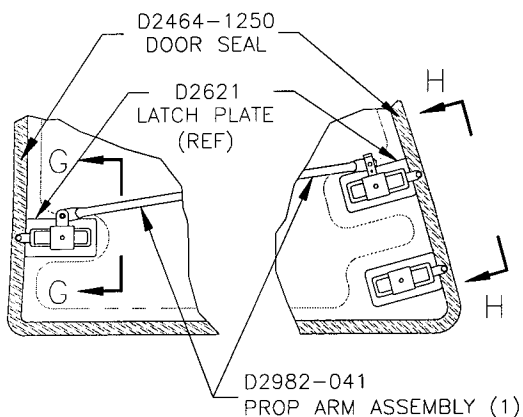
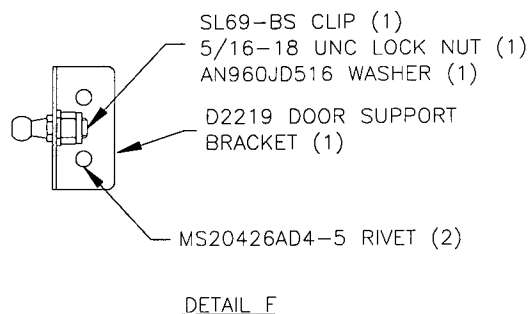


FIGURE 5. LOOKING AT TYPICAL INSIDE  
OF D350-600-145/-146 DOOR



**TC Accepted**  
**MAY 07 2003**

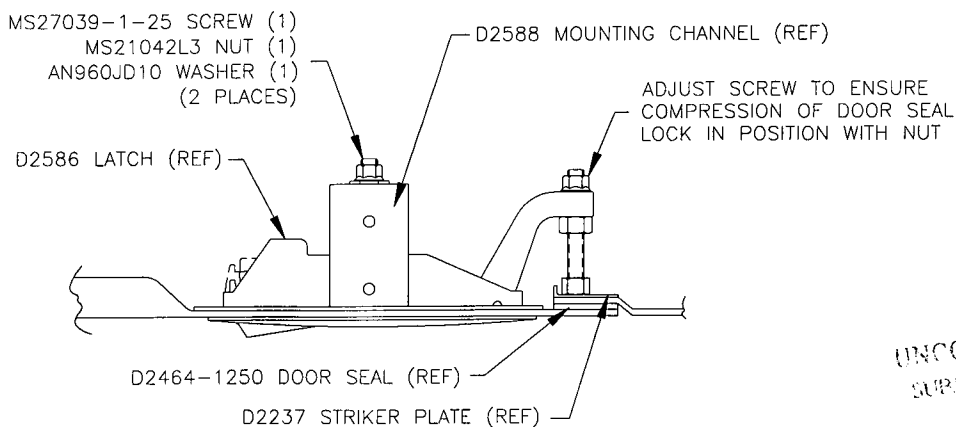
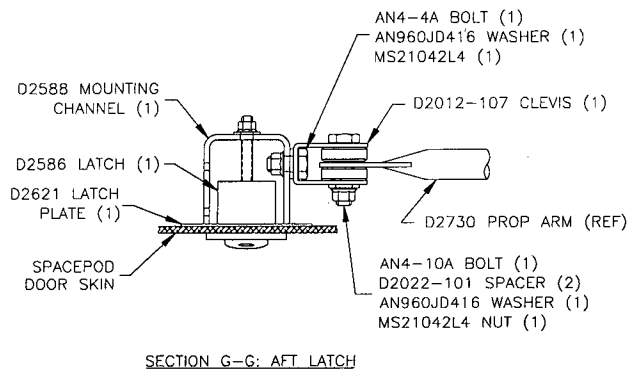
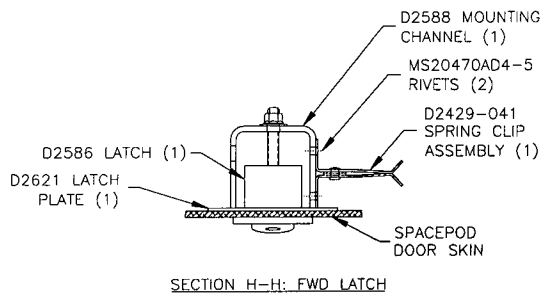
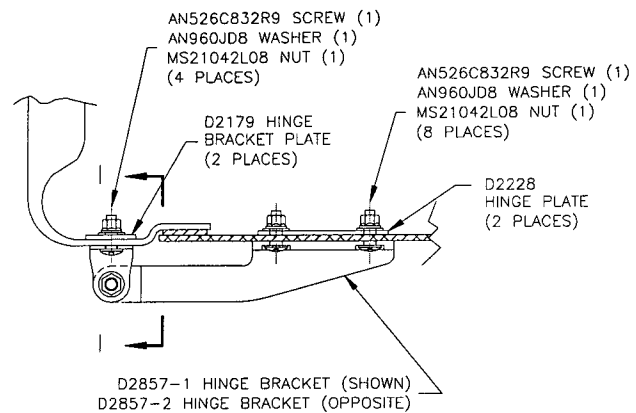
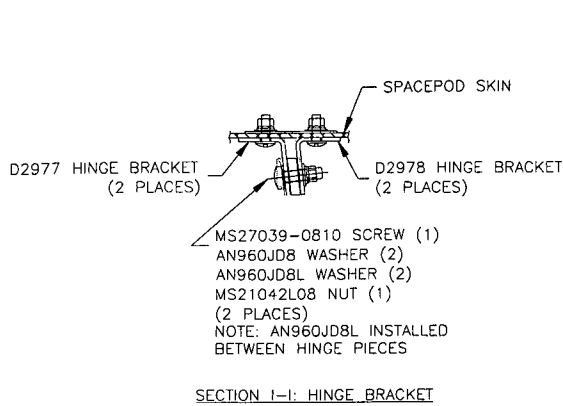


FIGURE 6. TYPICAL LATCH INSTALLATION

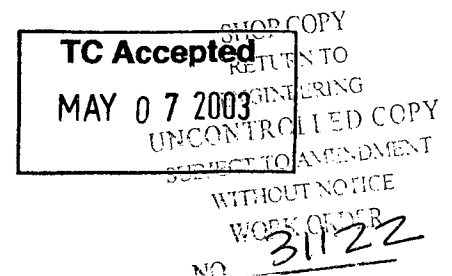
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122

• COPYRIGHT © 2000 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



## 25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.



• COPYRIGHT © 2000 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

RELEASED

07.02.27

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
JB	CE			
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 11	
DATE		TITLE	SCALE	
07.02.22		SPACEPOD BODY	NTS	
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		

**GENERAL NOTES:**

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

NO. 31122

Copyright © 2003 by DART AEROSPACE LTD

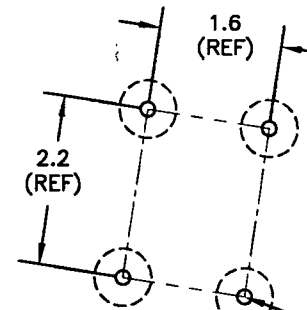
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

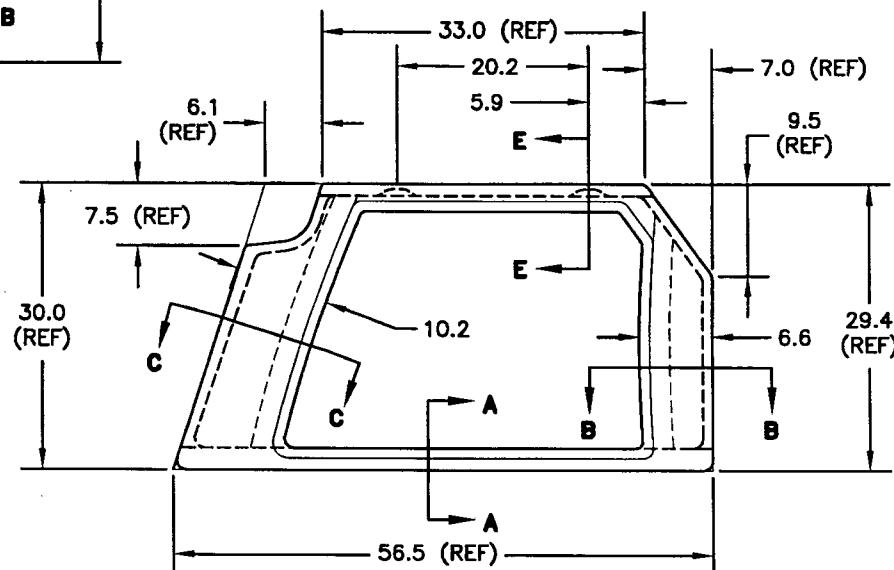
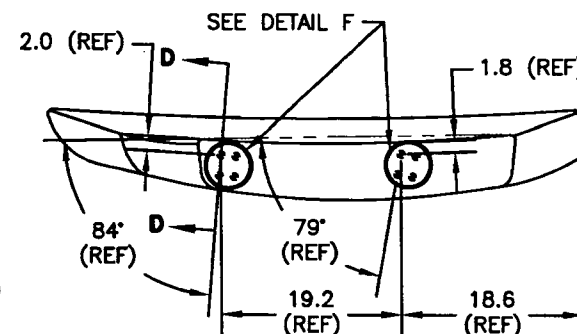
RELEASED

07.02.27

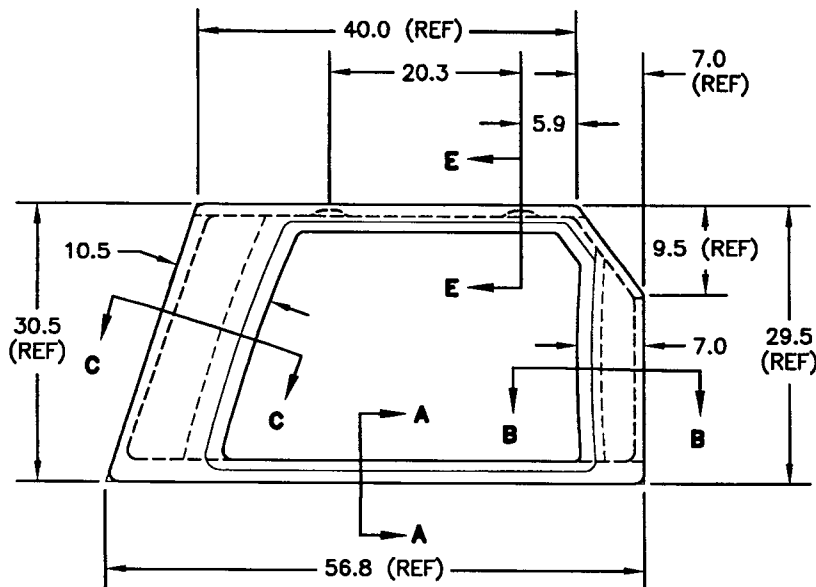
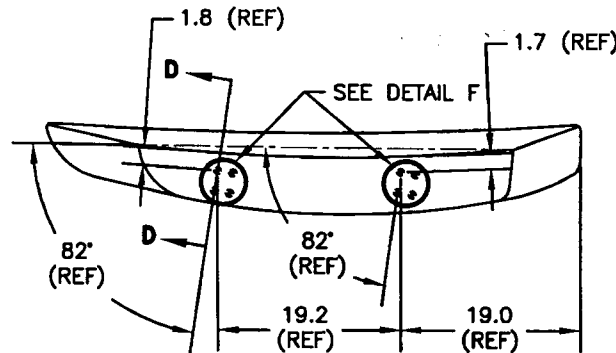
INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**DETAIL F**



**D3188-3M SPACEPOD BODY**



**D3188-1M SPACEPOD BODY**

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
JB	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 11
		D3188	
DATE	TITLE	SCALE	
07.02.22	SPACEPOD BODY	NTS	

**D3188-1M/-3M NOTES:**

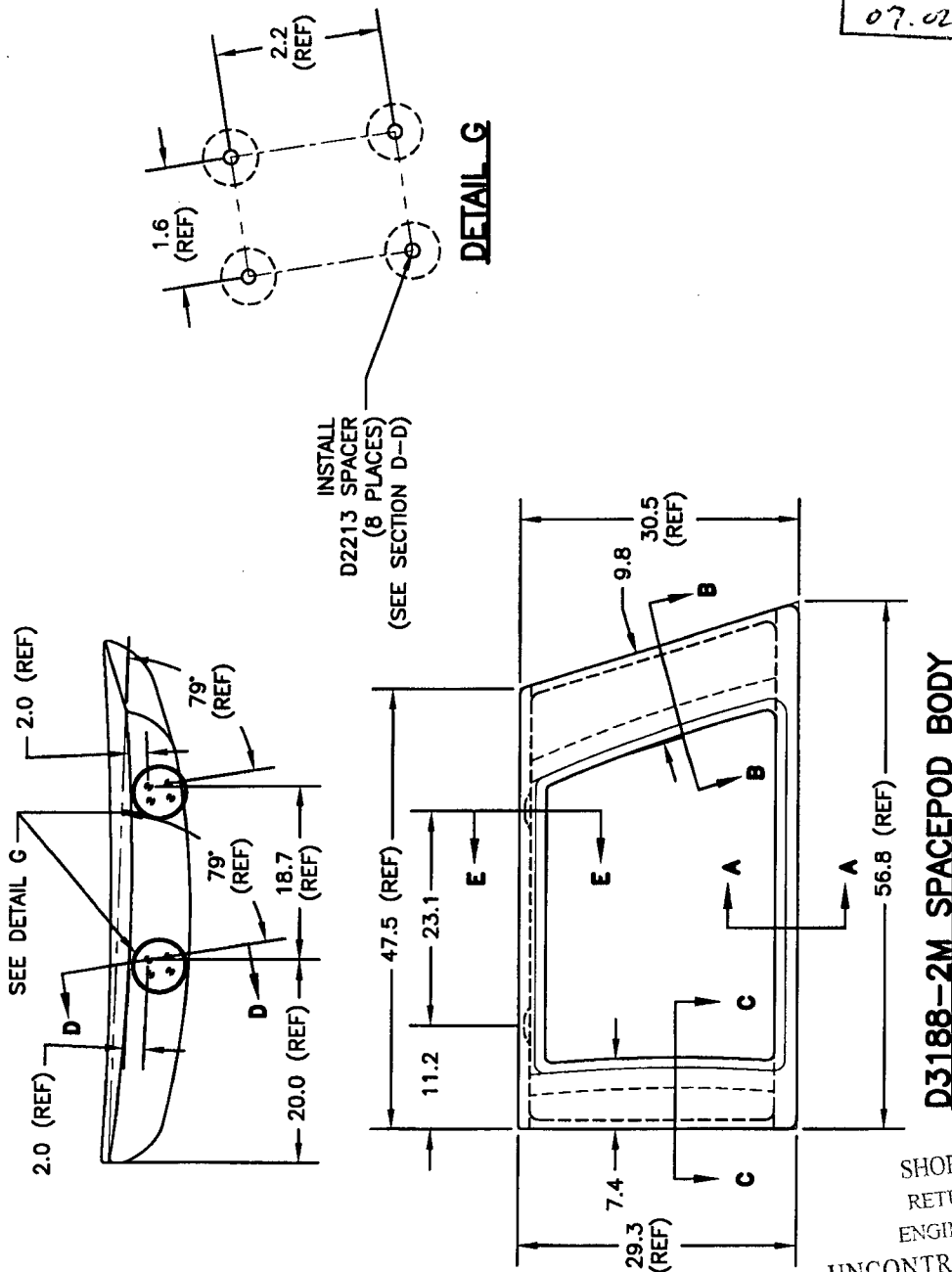
1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.

SHOP COPY  
RETURN TO  
DRAWING  
ENGINEERING  
DEPARTMENT  
FOR REVIEW  
DATE 3/1/22  
NO. 31122



**DART**

DESIGN <b>JB</b>	DRAWN BY <b>LE</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3188</b>	REV. D SHEET 3 OF 11
DATE <b>07.02.22</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS

**RELEASED**07.02.27 *[Signature]*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **31122**

D3186-2M NOTES:  
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2. SEE SHEET #4 FOR SECTION VIEWS.

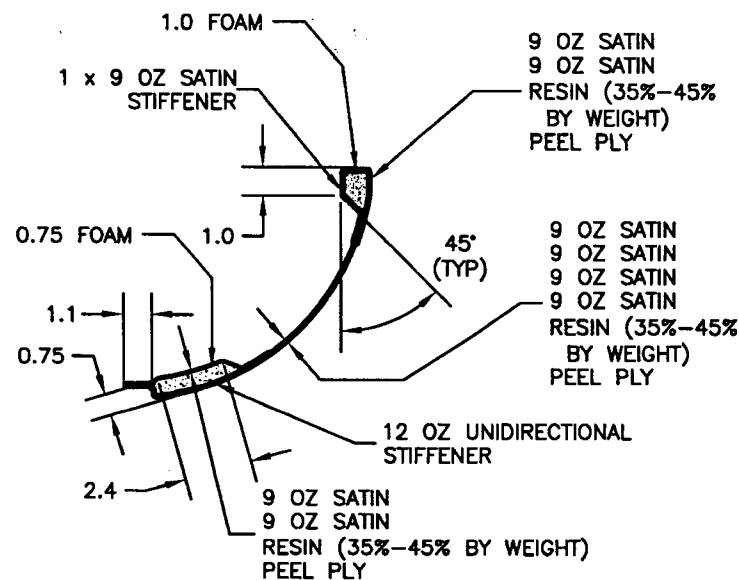
**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

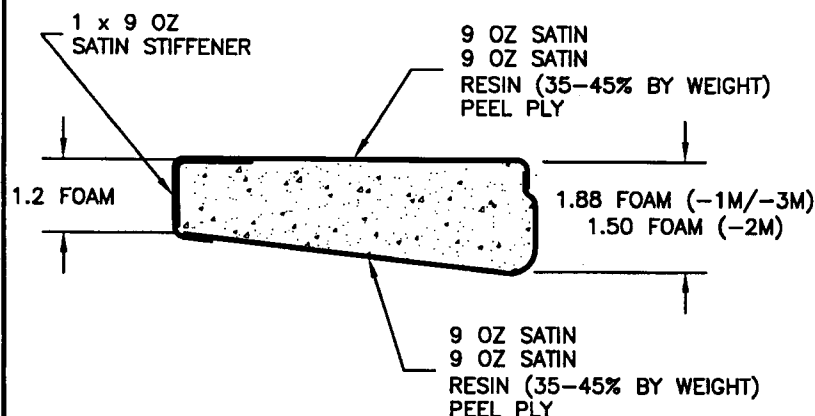
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
JB	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 4 OF 11
JB	JB	D3188	
DATE	TITLE	SCALE	
07.02.22	SPACEPOD BODY	NTS	

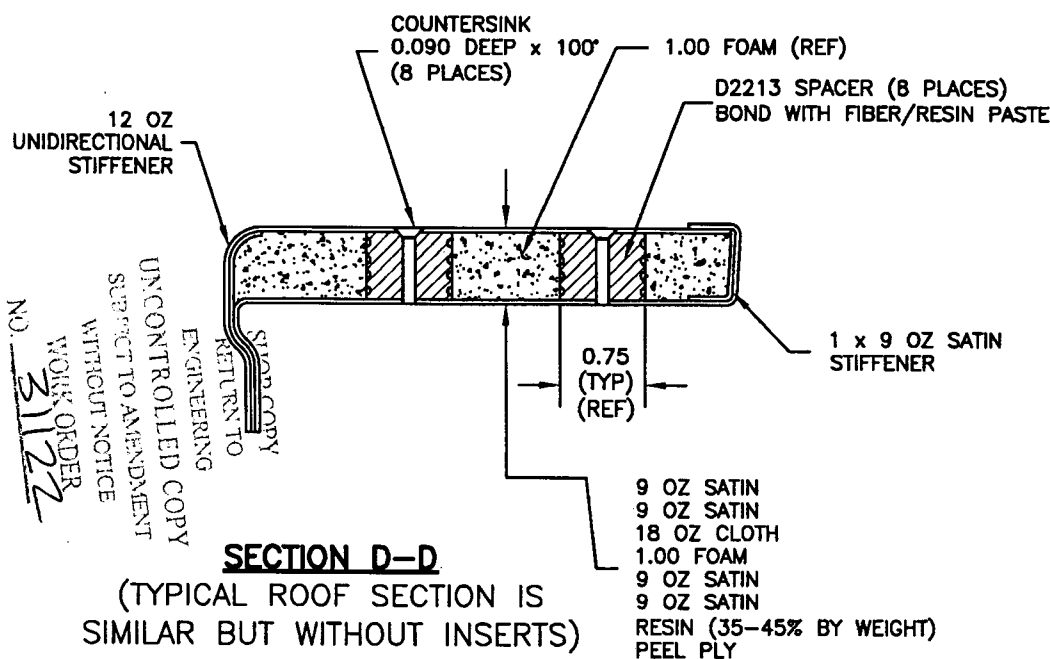
RELEASED  
07.02.27



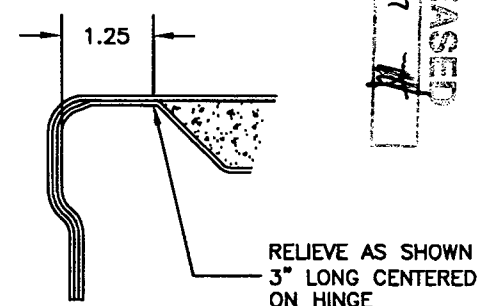
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



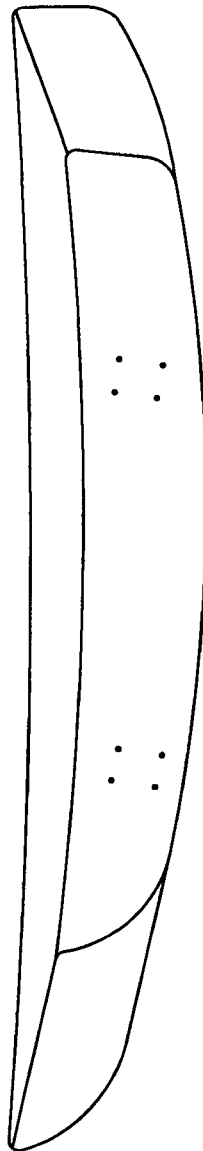
**SECTION E-E**  
(2 PLACES PER POD)

**DART**

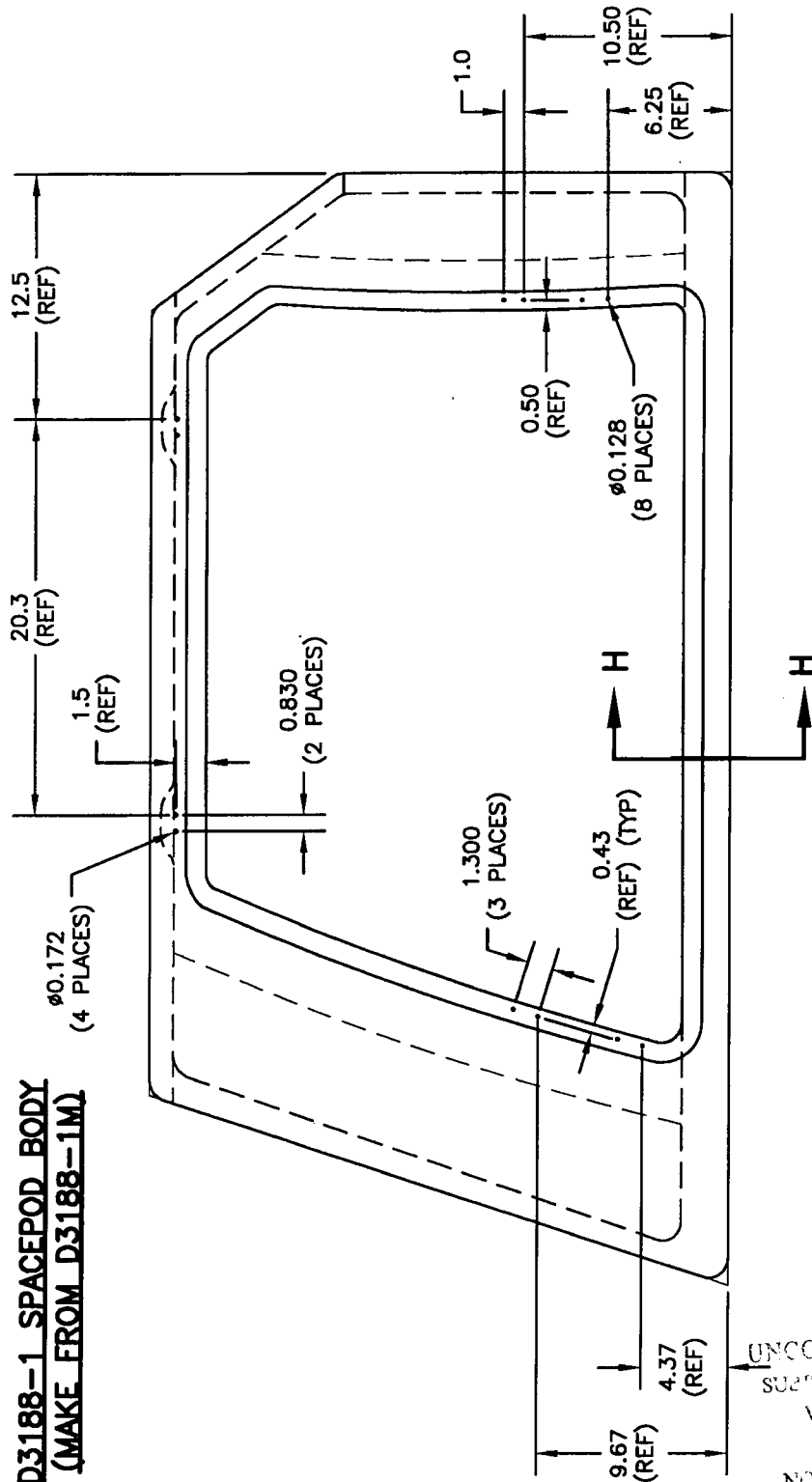
DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3188	REV. D SHEET 5 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07-02-27



**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



## NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUSCEPT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122

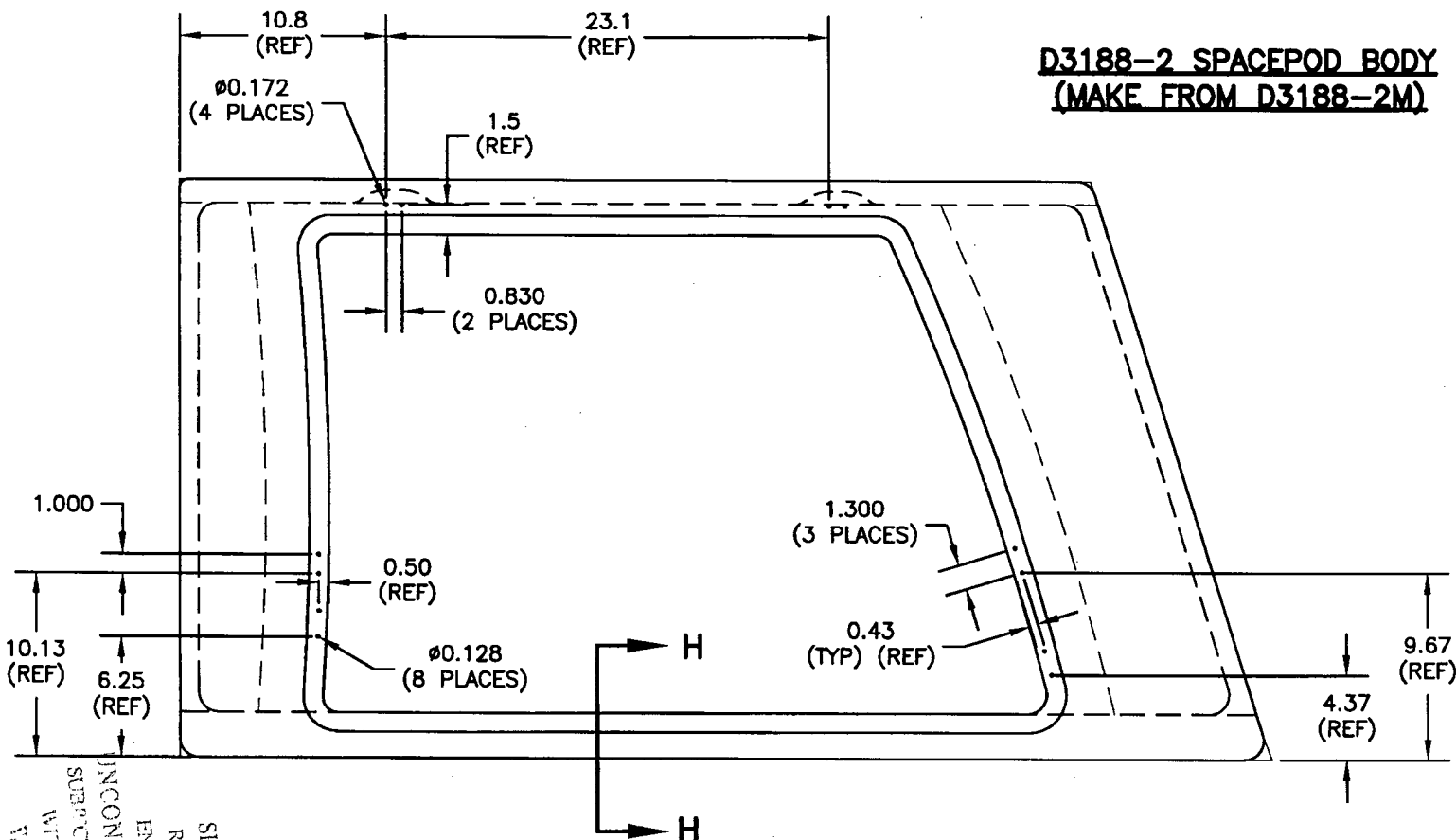
Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

RELEASED  
07.02.22

**D3188-2 SPACEPOD BODY**  
**(MAKE FROM D3188-2M)**



**NOTES:**

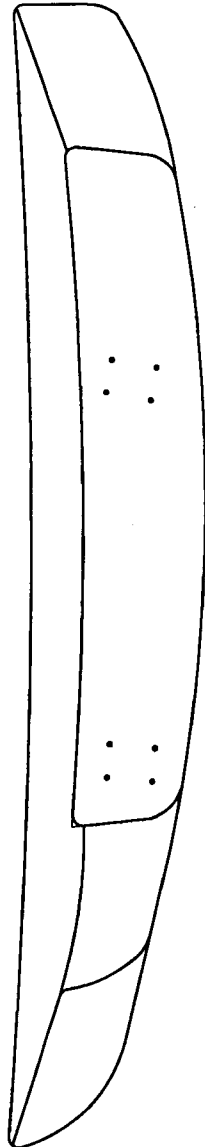
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
JB	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 6 OF 11
JB	CE	D3188	
DATE	TITLE	SCALE	NTS
07.02.22	SPACEPOD BODY		

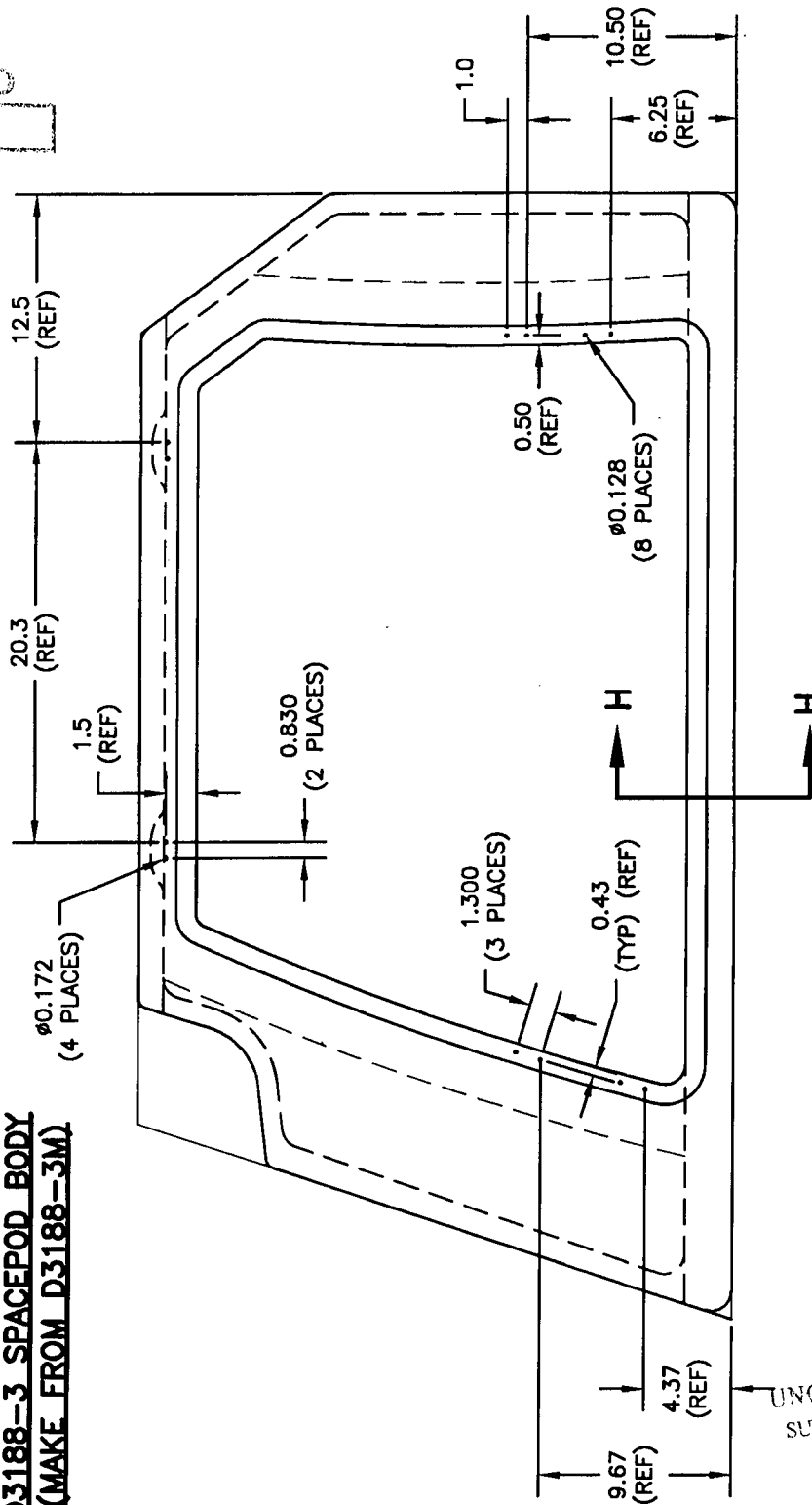


DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 7 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
07.02.27 [Signature]



**D3188-3 SPACEPOD BODY**  
**(MAKE FROM D3188-3M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

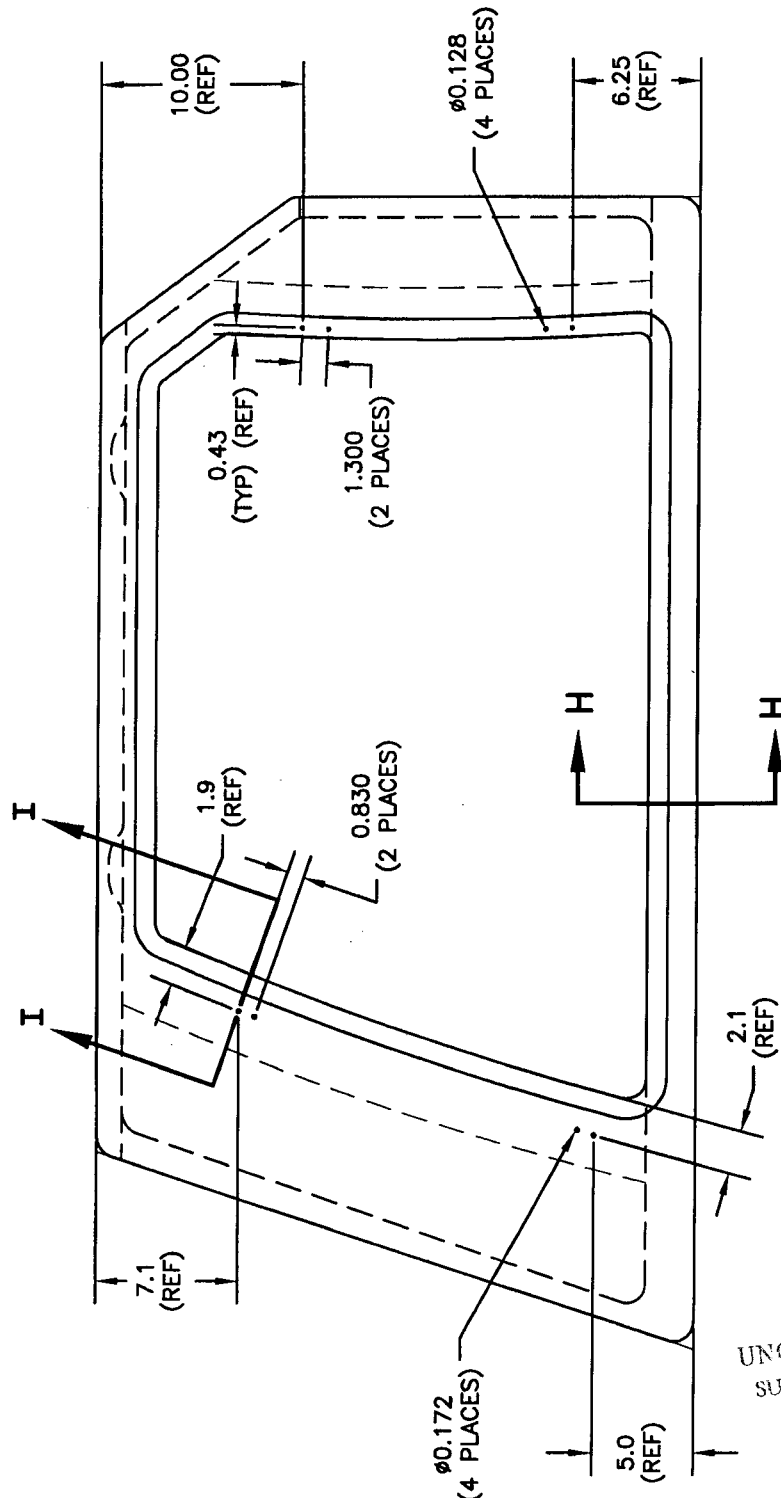
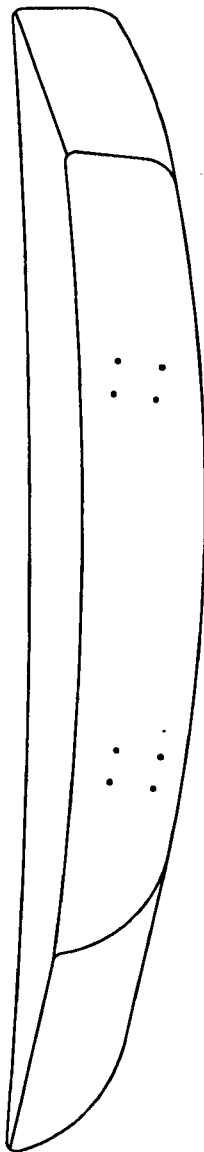
**DART**

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 8 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27 [Signature]

**D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

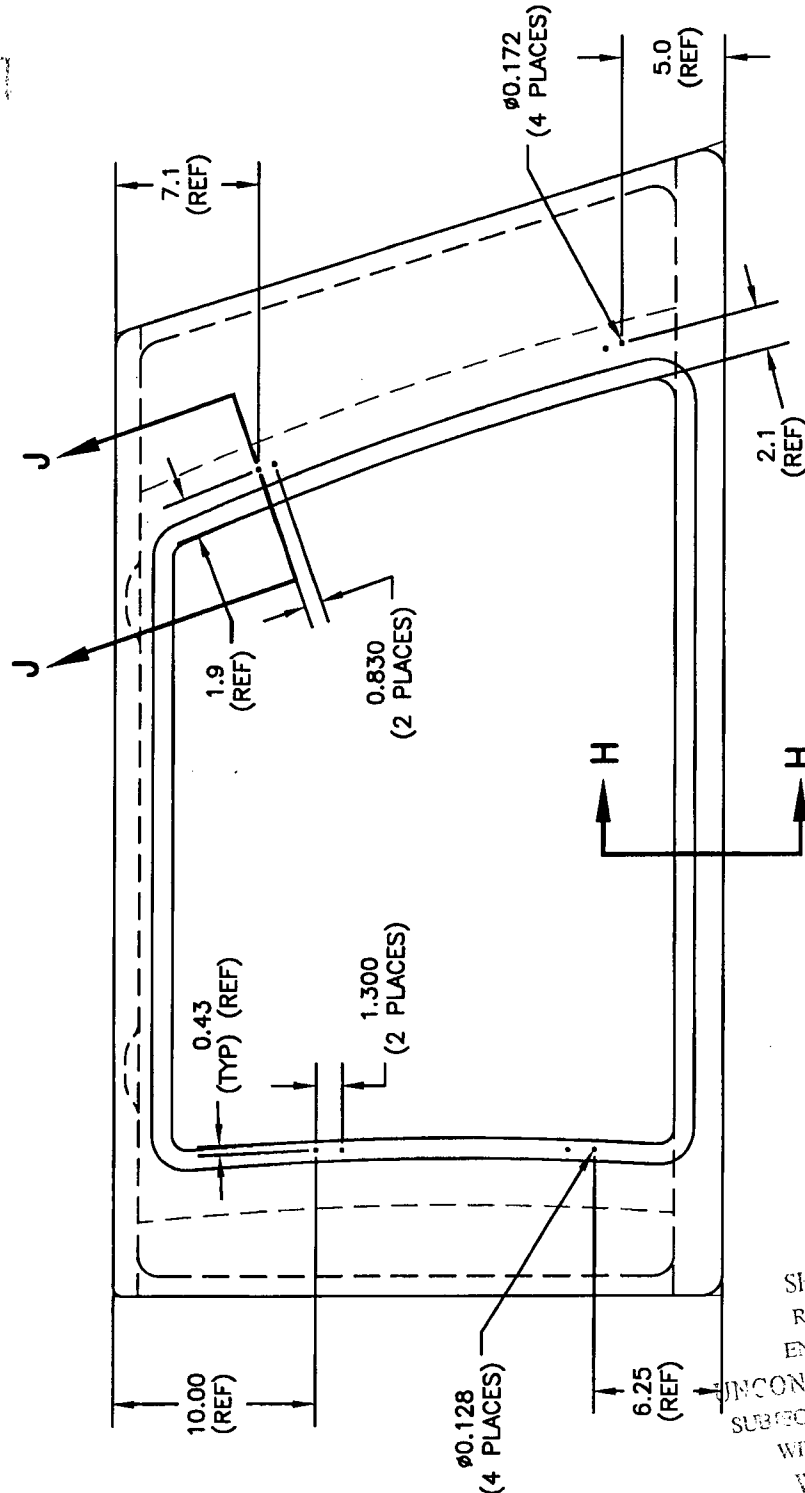
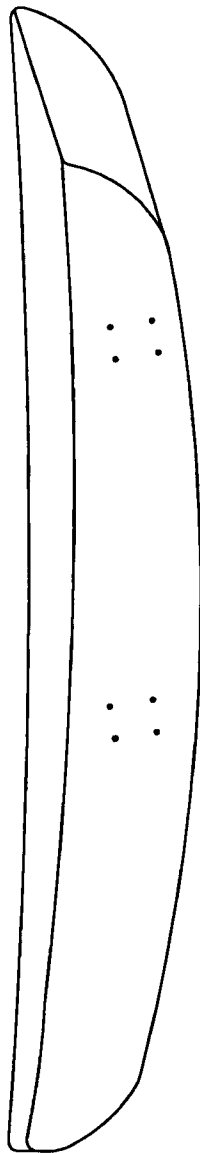
**DART**

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D3188	REV. D SHEET 9 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY	SCALE NTS	

RELEASED

07.02.27

**D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A REVISION  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

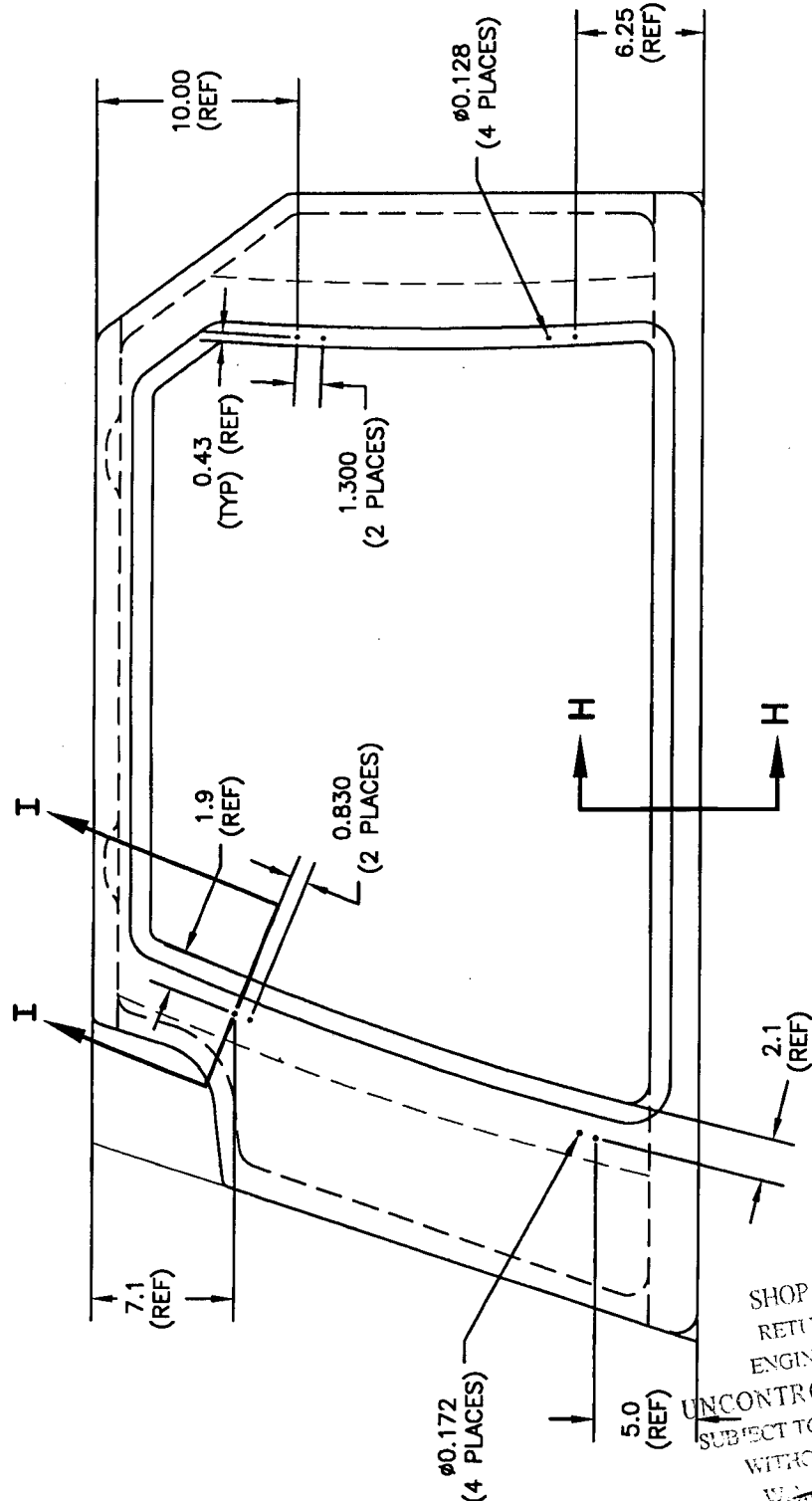
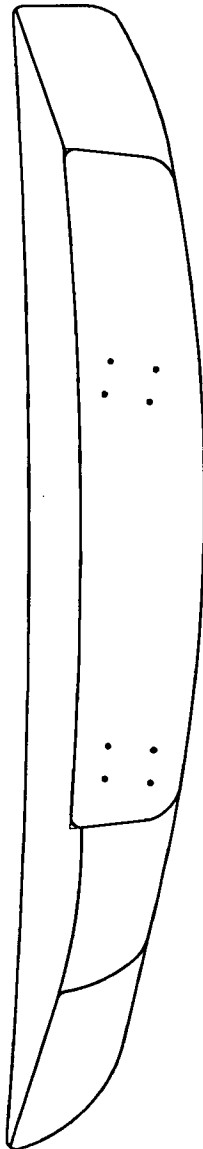
**DART**

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3188	REV. D SHEET 10 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07-02-27

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

NO. 31122

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**DART**

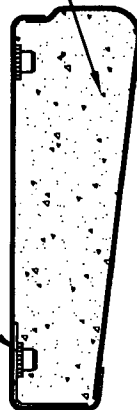
DESIGN <b>JB</b>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3188</b>	REV. D SHEET 11 OF 11
DATE <b>07.02.22</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS

RELEASED

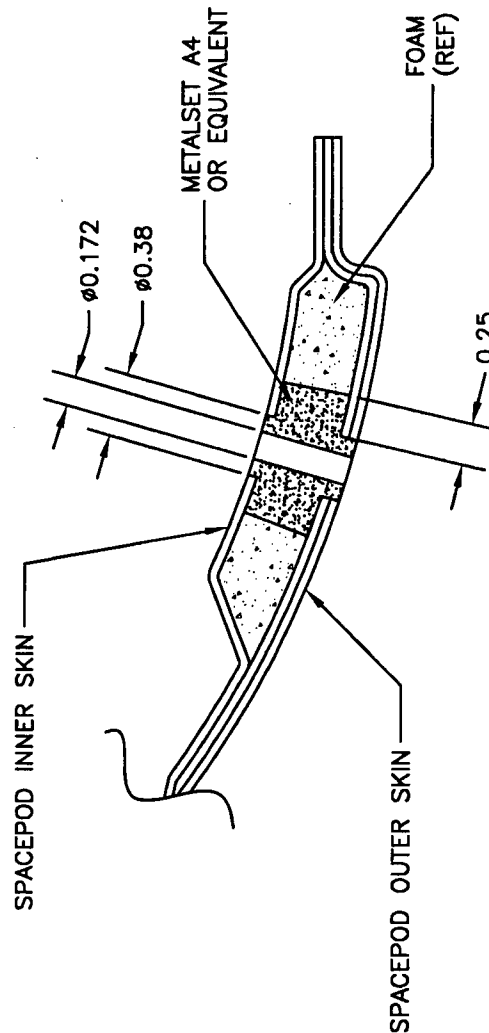
07.02.22 *H*

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Jeudi, 2007-03-29 10:33:33  
 Utilisateur: Marc Dubé

## Feuille de Procédé

<b>Client</b>	: DART Dart Aerospace Ltd.	<b>Nom Dessin</b>	: SPACEPOD BODY
<b>Numéro Job</b>	: 41314	<b>Numéro Article</b>	: DKC134-0055
<b>Numéro Soumission</b>	: 2587	<b>Numéro Dessin</b>	: D3188
<b>Numéro B.A.</b>	:	<b>Projet Numéro</b>	: DKC134
<b>Cette fois</b>	: 2007-03-29 <b>No. B.V.</b> :	<b>Révision dessin</b>	: B
<b>Prsht Rev.</b>	: NC	<b>Matériel</b>	: Fibre 7781 et Résine 411-350
<b>Prem. fois</b>	: - - <b>Type</b> :	<b>Date Due</b>	: 2007-04-05 <b>Qté:</b> 1 <b>UdM:</b> UNITE
<b>Job précédente</b>	: 41313		

Écrit par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace : D31882M



Process Sheet Rev.: 01 Modification générale selon les informations de l'ingénierie

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0	AC0303	Frekote 44NC
<b>Commentair</b>	Qty.: 0.050 UNITE(s)/Unit	Total : 0.050 UNITE(s)
	Frekote 44NC	

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



<b>Commentair</b>	Setup: 0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
	PRÉPARATION DU MOULE	

Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: JUN 27 2007 Heure Début: 7:30 Heure Fin: 9:30 Sceau:



3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

<b>Commentair</b>	Qty.: 9.84 VERGE(s)/Unit	Total : 9.84 VERGE(s)
	Tissu à délaminer Release ply B	

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

<b>Commentair</b>	Qty.: 9.27 VERGE(s)/Unit	Total : 9.27 VERGE(s)
	Wrightlon 5200 Bleu P3	

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

<b>Commentair</b>	Qty.: 6.00 VERGE(s)/Unit	Total : 6.00 VERGE(s)
	Feutre de drainage N° Airweave N 10	

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

<b>Commentair</b>	Qty.: 7.00 VERGE(s)/Unit	Total : 7.00 VERGE(s)
	Stretchlon 200 poche à vide Vert	

Date: Jeudi, 2007-03-29 10:33:33

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41314

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 11.400 VERGE(s)/Unit Total: 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

#LOT: 1-6170-2

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-5964-1

9.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentaire Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot: 1-6113-3

10.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 12/06/07 Heure Début: 8:00 Heure Fin: 12:00 Sceau:



12.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6167-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41314

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: JUN 27 2007

Heure Début: 12:30

Heure Fin: 12:40

Sceau:



16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: JUN 27 2007

Heure Début: 12:40

Heure Fin: 1:25

Sceau:



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 27 2007

Heure Début: 1:25

Heure Fin: 1:45

Sceau:



Curing Début: 12:40

Curing Fin: 8:00

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)  
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

Date: Jeudi, 2007-03-29 10:33:33  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

19.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
TAILLAGE DU MATÉRIEL

Tailler le Foam Core 1" selon le plan de découpe et les gabarits

Date: JUN 28 2007 Heure Début: 1:30 Heure Fin: 9:30 Sceau:



20.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6167-1

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

22.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

JUN 28 2007



Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

23.0 AAC0452 Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)  
Polybond B46F

N° de Lot: 1-6177-1

24.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

À l'aide du Polybond, coller ensemble les deux surfaces scellées

Disposer des point sur les pièces pour conserver une pression de collage.

Laisser sécher pour un minimum de deux heures.

Quantité: 1 Date: JUN 28 2007 Sceau:



Date: Jeudi, 2007-03-29 10:33:33  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

Quantité: Date: Sceau:

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: JUL 03 2007 Sceau:



Quantité: Date: Sceau:

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6213-1

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s)  
Catalyst N° DDM-9

N° de Lot:

1-5921-3

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

JUL 03 2007



Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par  
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs  
FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu 75 minutes. Selon I.G.# Sceller le foam Core.

Laisser sécher pendant 2 heures minimum.

Date: JUL 03 2007

Sceau:



Initiales: C.G.-S.V.

Date: Jeudi, 2007-03-29 10:33:33  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)  
Polybond B46F N° de Lot: 1-6177-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.  
Date: JUL 03 2007

Heure Début: 2:10 Heure Fin: 2:15 Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
ASSEMBLAGE GÉNÉRALE DES PIECES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond

Date: JUL 03 2007

Heure Début: 2:15 Heure Fin: 2:45 Sceau:



33.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: JUL 03 2007

Heure Début: 2:45 Heure Fin: 3:00 Sceau:



Curing Début: 2:15 Curing Fin: 3:20

Date: Jeudi, 2007-03-29 10:33:33  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikks

Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikks

N° de Lot: 1-6079-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikks

Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)  
Durcisseur Polysoft #004009 Sikks

36.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikks. Pour les plus gros défauts utiliser du polybond

Date: JUL 04 2007 Heure Début: 7:30 Heure Fin: 12:00 Sceau:



37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

JUL 04 2007



Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6213-1

39.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

40.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

JUL 04 2007



Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core

Laisser sécher pendant minimum deux heures.



Date: Jeudi, 2007-03-29 10:33:33  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

41.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6213-1

43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUL 05 2007

Heure Début: 7:45

Heure Fin: 7:50

Sceau:



44.0	INSPECTION 3	INSPECTION PIÈCE DART
------	--------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: JUL 05 2007

Heure Début: 7:50

Heure Fin: 8:40

Sceau:



45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Jeudi, 2007-03-29 10:33:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: 05 2007 Heure Début: 8:40 Heure Fin: 9:00 Sceau:



Curing Début: 7:50 Curing Fin: 1:30

46.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
DÉMOULAGE DES PIECES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 05 2007 Heure Début: 1:30 Heure Fin: 2:15 Sceau:



47.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers N° D2213 ( ne pas percer la peau extérieur de la pièce )

Date: 06 2007 Heure Début: 10:15 Heure Fin: 11:00 Sceau:



48.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

49.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

50.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)  
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job: 


# Séq.: Machine ou Opération: Description :

51.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUL 10 2007 Heure Début: 10:15 Heure Fin: 10:20 Sceau: 

52.0 AAC0448 Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)  
Spacer N° D2213 N° de Lot: 1-5949-1

53.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART




Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs  
ASSEMBLAGE GÉNÉRALE DES PIECES

Faire l'assemblage des inserts ( Spacer ) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer un pression sur les pièces de 9 ox à l'aide d'un bloc de bois et de pinces autobloquantes

Laisser sécher pendant 4 heures minimum.

Date: JUL 10 2007 Heure Début: 10:20 Heure Fin: 11:10 Sceau: 

Curing Début: 10:20 Curing Fin: 2:30

54.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

55.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

Date: Jeudi, 2007-03-29 10:33:34

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41314

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

56.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIELFaire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par  
quantité de résine N° 411-350.

Date: JUL 09 2007

Heure Début: 12:30

Heure Fin: 12:35

Sceau:



57.0

LAMINAGE.

LAMINAGE PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs  
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièces. Selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: JUL 09 2007

Heure Début: 12:35

Heure Fin: 1:30

Sceau:



Curing Début: 12:35

Curing Fin: 8:00

58.0

FINITION 3

FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

Repercer les 8 trous des spacers afin de les déboucher

JUL 11 2007



Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

01-807



59.0

AAC0671

Dupont Primer N° 1104S

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S

N° de Lot: 1-6065-2

60.0

AAC0670

Dupont Activation N° 7975S

Commentaire Qty.: 1.0000 PINTÉ(s)/Unit Total : 1.0000 PINTÉ(s)  
Dupont Activation N° 7975S

N° de Lot: 1-6149-3

Date: Jeudi, 2007-03-29 10:33:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41314

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S

N° de Lot: 1-6065-3

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

AUG 01 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PEINTURE / PRIMER DART

Appliquer une couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon I.G. #  
Application du primer

Laisser sécher pendant 3 heures minimum

Date: AUG 01 2007

Heure Début: 1:15 Heure Fin: 2:00 Sceau:



64.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 627  
1-6065-1

65.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

66.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide du Sikkens

Faire un léger sablage ( Grit 220 ) de toute les surfaces.

Date: 02-8-07 Heure Début: 7:45 Heure Fin: 11:20 Sceau:



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41314

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

67.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.2500 GALLON(s)/Unit Total: 0.2500 GALLON(s)

Dupont Primer N° 1104S N° de Lot: 1-6065-2

68.0 AAC0670 Dupont Activator N° 7975S

Commentaire Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s)

Dupont Activator N° 7975S N° de Lot: 1-6065-1

69.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s)

Dupont Reducer N° 12375S N° de Lot: 1-6065-3

70.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

PRÉPARATION DU MATÉRIEL

AUG 02 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

71.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs

APPLICATION DE PRIMER

Appliquer deux couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.

Laisser sécher pendant 3 heures minimum

Date: AUG 02 2007

Heure Début: 11:15

Heure Fin: 12:00

Sceau:



72.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 9-08-07

Sceau:



Initiales: H.S.

73.0 EMBALLAGE 3 EMBALLAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.

Date: Jeudi, 2007-03-29 10:33:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41314

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 9/8/07 Sceau:

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Date: Jeudi, 2007-03-29 10:34:26  
 Utilisateur: Marc Dubé


## Feuille de Procédé

 Client : DART Dart Aerospace Ltd.  
 Numéro Job : 41333  
 Numéro Soumission : 2586  
 Numéro B.A. :  
 Cette fois : 2007-03-29 No. B.V. :  
 Prsht Rev. : NC  
 Prem. fois : - Type :  
 Job précédente : 41332

 Nom Dessin : SPACEPOD DOOR  
 Numéro Article : DKC134-0054  
 Numéro Dessin : D3186  
 Projet Numéro : DKC134  
 Révision dessin : C  
 Matériel : Fibre 7781 et Résine 411-350  
 Date Dûe : 2007-04-05 Qté: 1 Udm: UNITE

 Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Dart Aerospace : D31862M

Process Sheet Rev.: 01 Modification générale selon les informations de l'ingénierie.

 Modif. à venir  ns. 1-08-07

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :


1.0 AC0303 Frekote 44NC

 Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)  
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: JUN 21 2007 Heure Début: 2:00 Heure Fin: 4:30 Sceau: 

3.0 AC0409 Tissu à délaminer Release ply B

 Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)  
 Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

 Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)  
 Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

 Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)  
 Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert

 Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)  
 Stretchlon 200 poche à vide Vert



Date: Jeudi, 2007-03-29 10:34:26

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41333Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish
Commentaire Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s) 9.7 oz Weave #FG-778150-125Y Volan Finish #LOT: 1-6170-2		
8.0	AAC0443	Fiberglass 12 oz Unidirectional
Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s) Fiberglass 12 oz Unidirectional N° de Lot: 1-5964-1		
9.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
Commentaire Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s) Ruban à gommer jaune #: T/AT-200Y		

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 4/06/07 Heure Début: 10:15 Heure Fin: 12:00 Sceau:



11.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)  
Catalyst N° DDM-9 N° de Lot: 1-5921-3

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-6167-1

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 22 2007 Heure Début: 1:05 Heure Fin: 1:10 Sceau:



Date: Jeudi, 2007-03-29 10:34:26

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41333

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

14.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: JUN 22 2007 Heure Début: 1:10 Heure Fin: 1:25 Sceau:



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 22 2007 Heure Début: 1:25 Heure Fin: 1:35 Sceau:



Curing Début: 1:10 Curing Fin: 8:00

16.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6167-1

Date: Jeudi, 2007-03-29 10:34:26

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41333

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: JUN 26 2007 Heure Début: 10:15 Heure Fin: 10:30 Sceau:



19.0

AAC0452

Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)  
Polybond B46F N° de Lot: 1-6177-1

20.0

DKC134-0057

Foam Core N° D3186-102 ( Porte D3186-2 )

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Foam Core N° D3186-102 ( Porte D3186-2 ) #LOT: 1-5826-1

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: JUN 26 2007 Heure Début: 2:15 Heure Fin: 2:30 Sceau:



22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Date: Jeudi, 2007-03-29 10:34:26

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41333

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond

Date: JUN 26 2007 Heure Début: 2:30 Heure Fin: 2:40 Sceau: 65



Curing Début: 2:15 Curing Fin: 3:20

23.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total: 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-5921-3

24.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6167-1

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 27 2007 Heure Début: 9:00 Heure Fin: 9:10 Sceau: 62



26.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: JUN 27 2007 Heure Début: 9:10 Heure Fin: 9:40 Sceau: 62



Date: Jeudi, 2007-03-29 10:34:26

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41333

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE





Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 27 2007 Heure Début: 9:40 Heure Fin: 10:00 Sceau:  

Curing Début: 9:10 Curing Fin: 1:30


28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.

Date: JUN 27 2007 Heure Début: 1:45 Heure Fin: 1:55 Sceau: 

29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: JUN 27 2007 Heure Début: 2:00 Heure Fin: 2:20 Sceau: 

30.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S

N° de Lot: 1-6149-1

Date: Jeudi, 2007-03-29 10:34:26  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41333

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:      Machine ou Opération:      Description :

31.0      AAC0670      Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S

N° de Lot: 1-6005-1

32.0      AAC0672      Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S

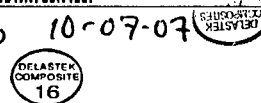
N° de Lot: 1-6005-3

33.0      PRÉPARATION 3      PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Nettoyage 10-07-07  
JUL 10 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0      PRÉPARATION 3      PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application primer

Laisser sécher pendant 3 heures.

Date: JUL 10 2007

Heure Début:

Heure Fin:

Sceau:



35.0      FINITION 3      FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

Date: Jeudi, 2007-03-29 10:34:26

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41333

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

37.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

38.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: 12-7-07 Heure Début: 8:00 Heure Fin: 10:00 Sceau:



39.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-60149-1

40.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-60065-1

41.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-60065-3

42.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs MASQUAGE + Nettoyage 12-07-07  
PRÉPARATION DU MATÉRIEL

JUL 12 2007

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le  
mélange selon les instruction du fabriquant.

31/07/07



43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
APPLICATION DE PRIMERAppliquer une deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application de primer.

JUL 12 2007

Date: 31/07/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:



Date: Jeudi, 2007-03-29 10:34:26  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41333

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

44.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
INSPECTION PIÈCE DART

Qty: 1 1-08-07



H.S.

Emballage QT 1

1/8/07





Date: Thursday, 3/8/2007 1:19:04 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY RH
Job Number	: 31122B		
Estimate Number	: 12596		
P.O. Number	:	Part Number	: D31882M
This Issue	: 3/8/2007 S.O. No. :	Drawing Number	: D3188 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: D
Previous Run	: 31121B	Material	:
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8	D2213	Spacer	Batch: _____
---	-------	--------	--------------

*sl w/030090*

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: \_\_\_\_\_  
 Description: D3188-2M BODY  
 SHIP: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:19:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 31122B

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 0709.18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

**DART**

RELEASED

07.02.22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
JB	CE	DRAWING NO.	D3188	SHEET 1 OF 11
CHECKED	APPROVED	DATE	07.02.22	SCALE
		TITLE	SPACEPOD BODY	NTS
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		

**GENERAL NOTES:**

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART  
D3188-1M/-1/-5  
D3188-2M/-2/-6  
D3188-3M/-3/-7

LAYUP  
DT8003  
DT8004  
DT8500

TRIM AND DRILL  
DT8501  
DT8502  
DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

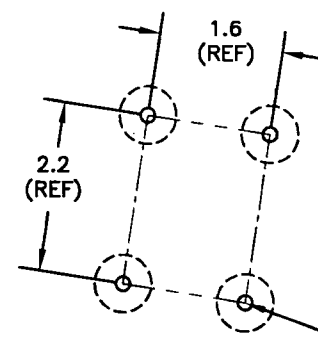
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINEERING  
UNCHECKED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 311225



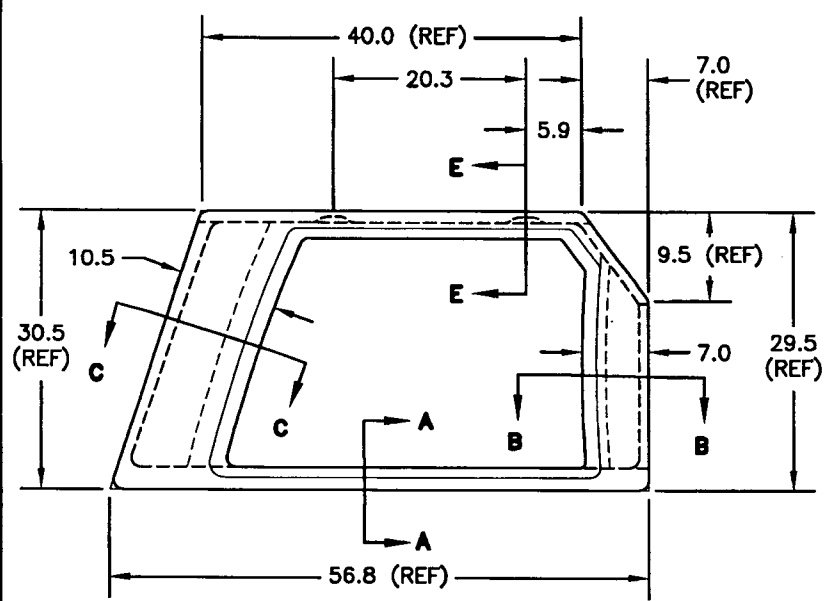
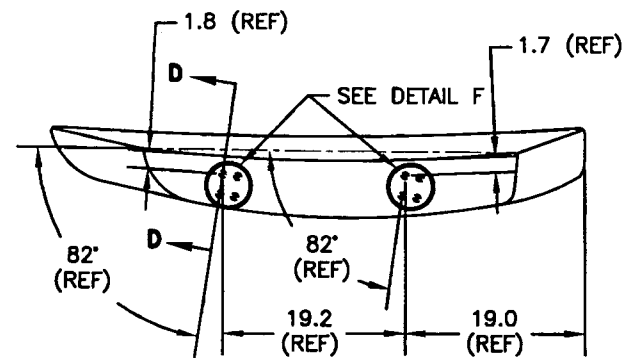
RELEASED

07.02.22

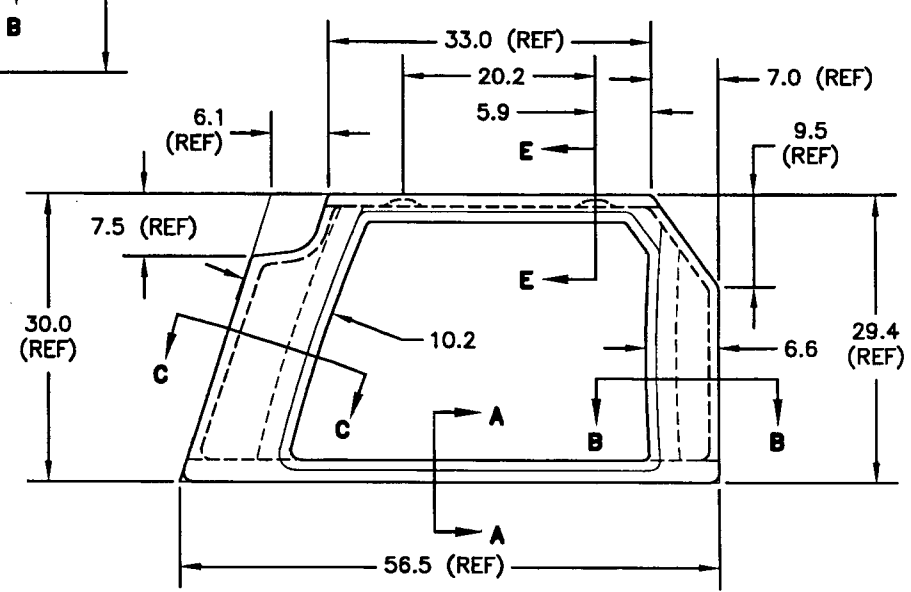
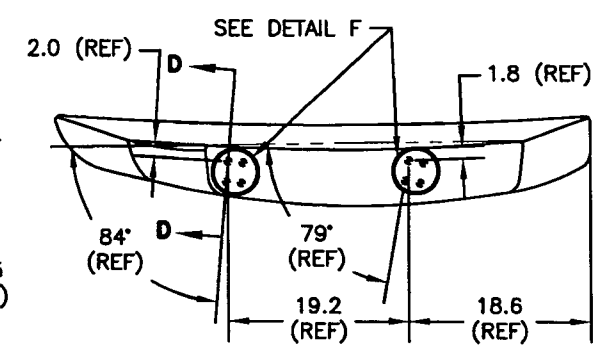


**DETAIL F**

INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

DESIGN	J8	DRAWN BY	CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		
DATE	07.02.22	DRAWING NO.	D3188	
TITLE	SPACEPOD BODY	SHEET 2 OF 11	REV. D	

SCALE  
NTS

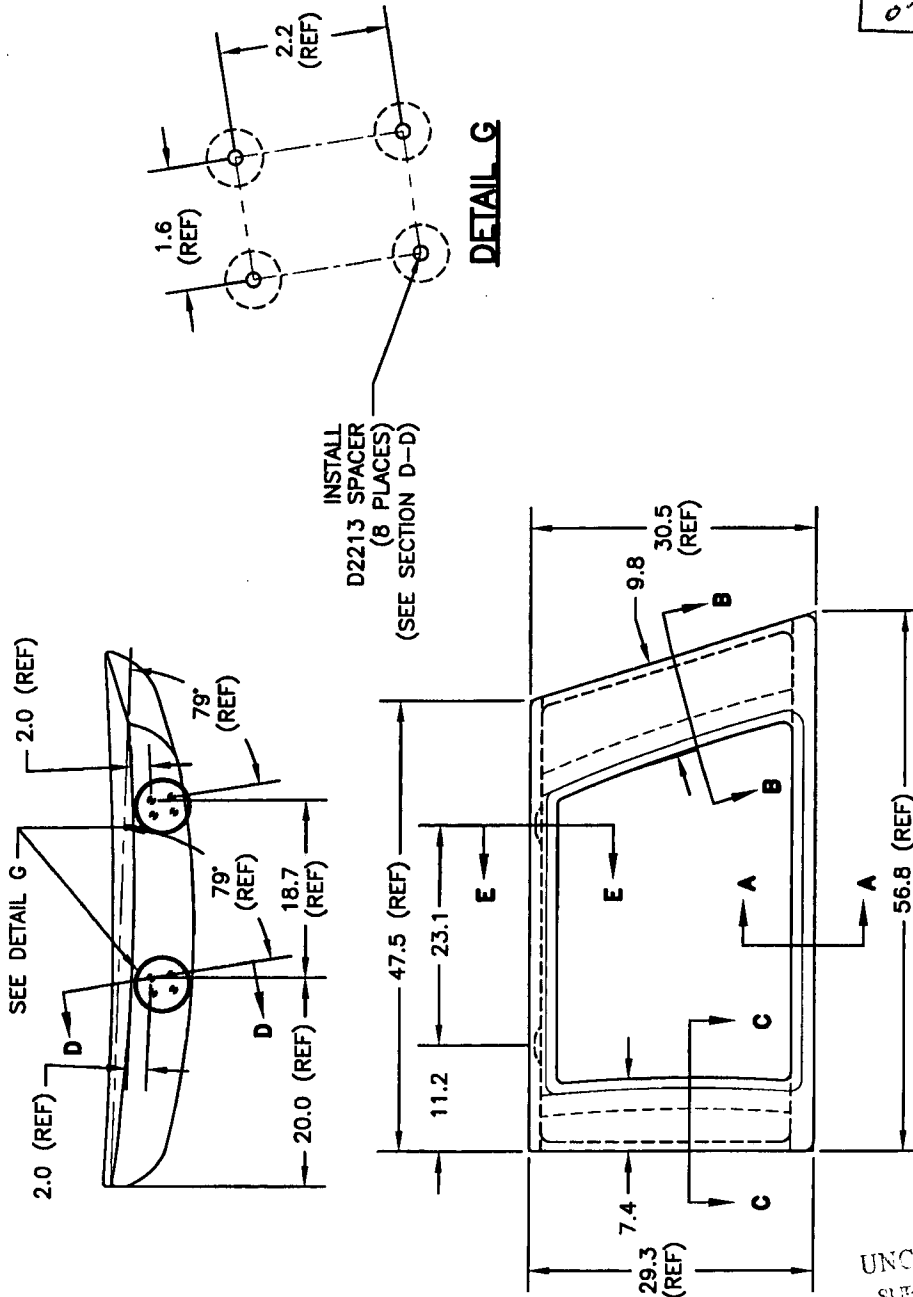
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SECTION 10.1.1.1  
WITHOUT NAME  
NO. 31122B

**D3188-1M/-3M NOTES:**

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>LE</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3188</b>	REV. D SHEET 3 OF 11
DATE <b>07.02.22</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS

**RELEASED****07.02.27****D3188-2M SPACEPOD BODY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **31122B**

D3188-2M NOTES:  
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2. SEE SHEET #4 FOR SECTION VIEWS.

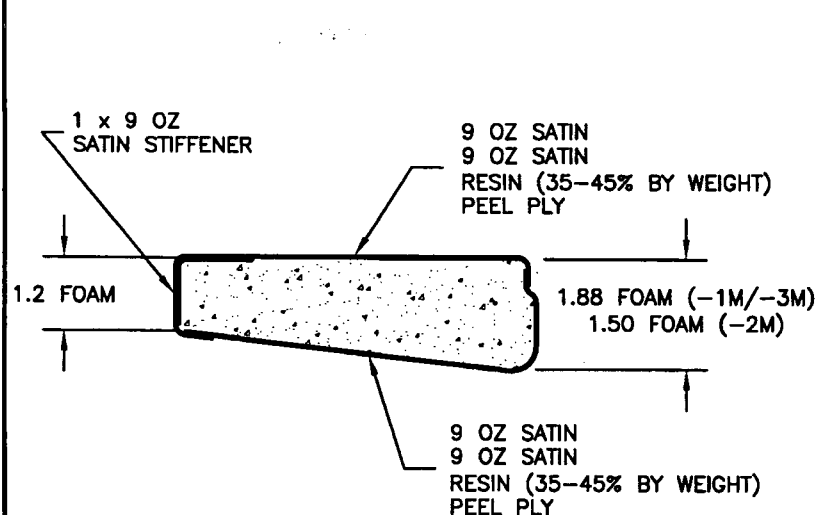
**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

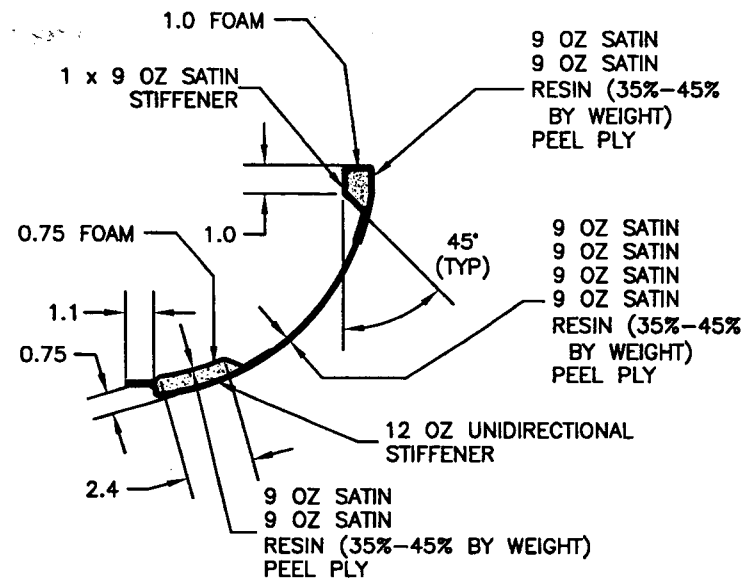


DESIGN	JB	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED		APPROVED	H	HAWKESBURY, ONTARIO, CANADA
DATE	07.02.22	TITLE	D3188	REV. D
			SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

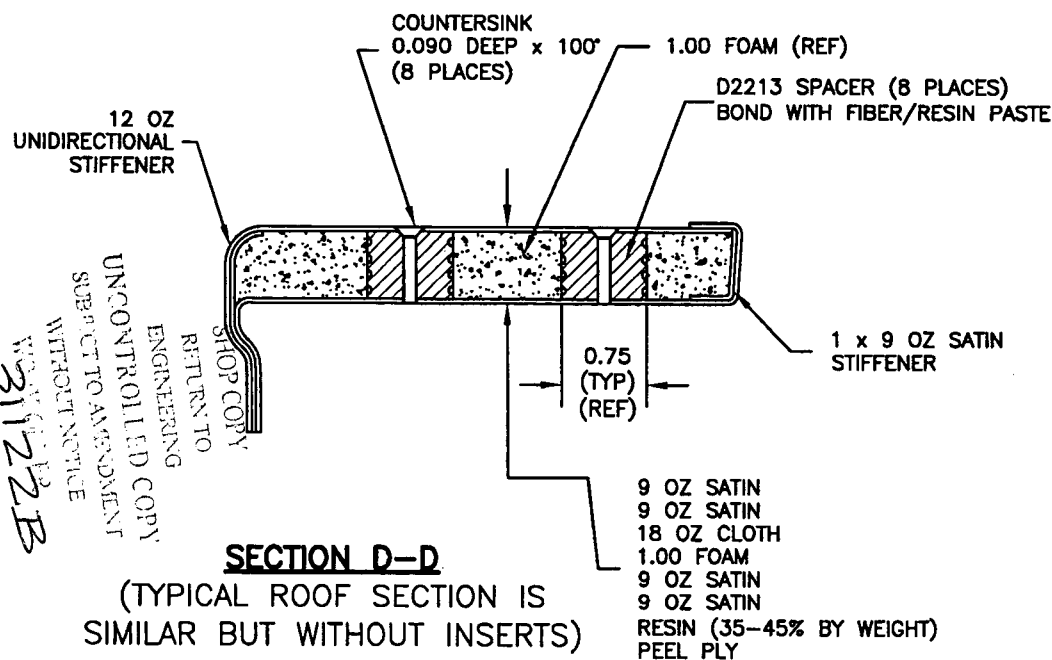
RELEASED  
07.02.27



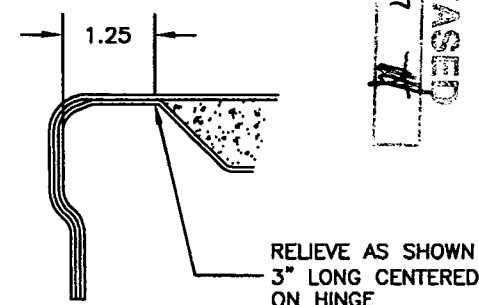
**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



**SECTION E-E**  
(2 PLACES PER POD)

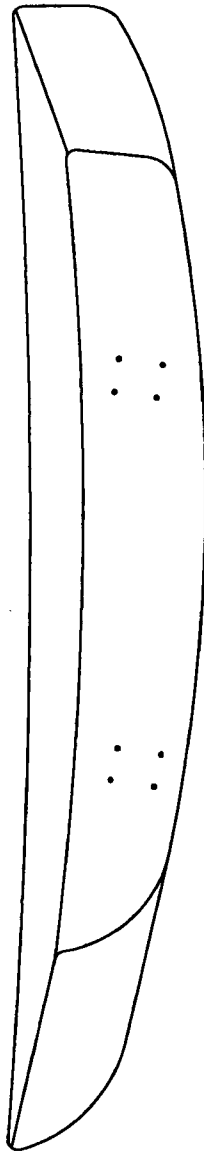




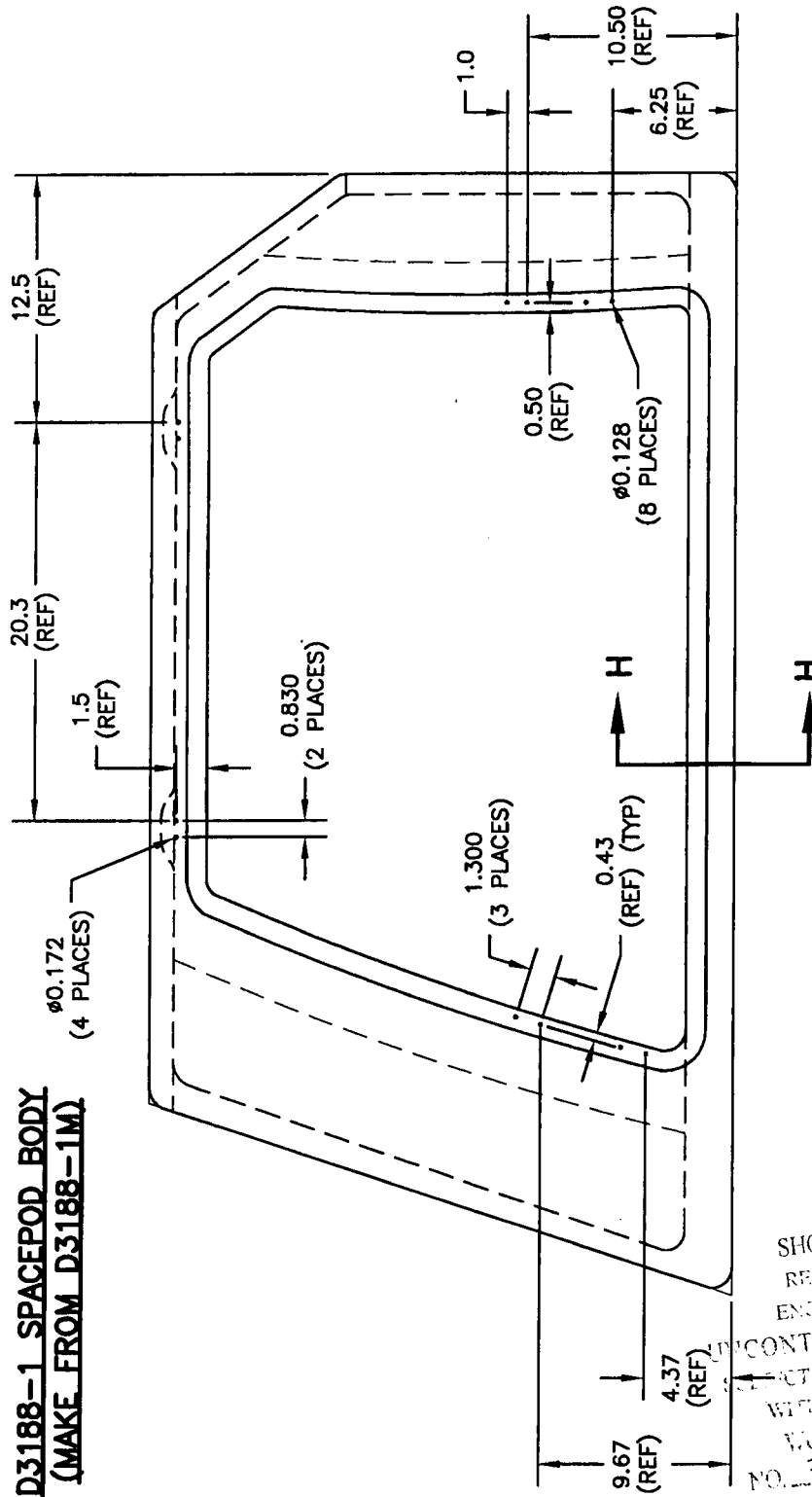
DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 5 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07-02-22 [Signature]



**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
CONTACT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122B

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

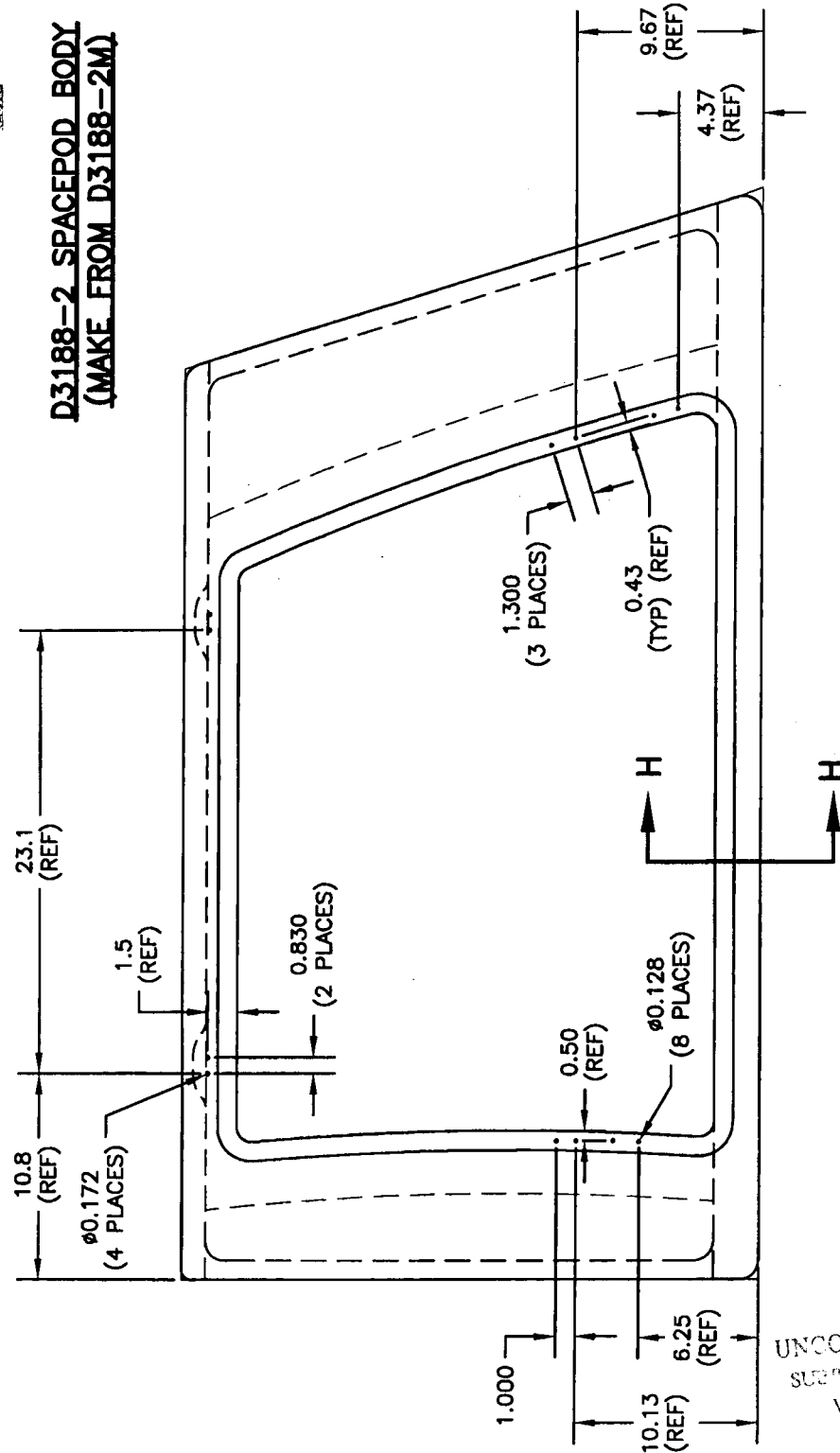
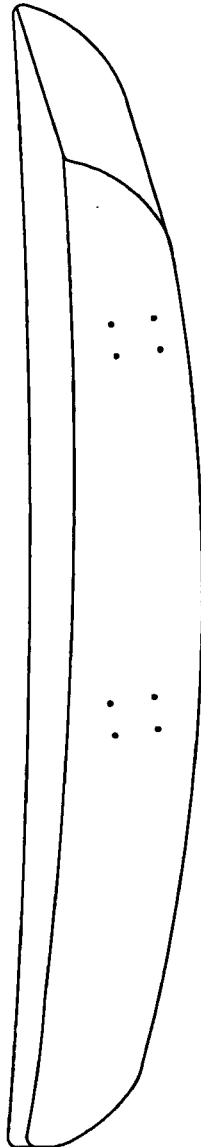
**DART**

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 6 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

**D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



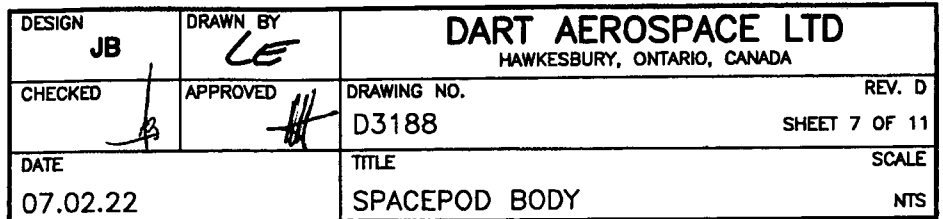
**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

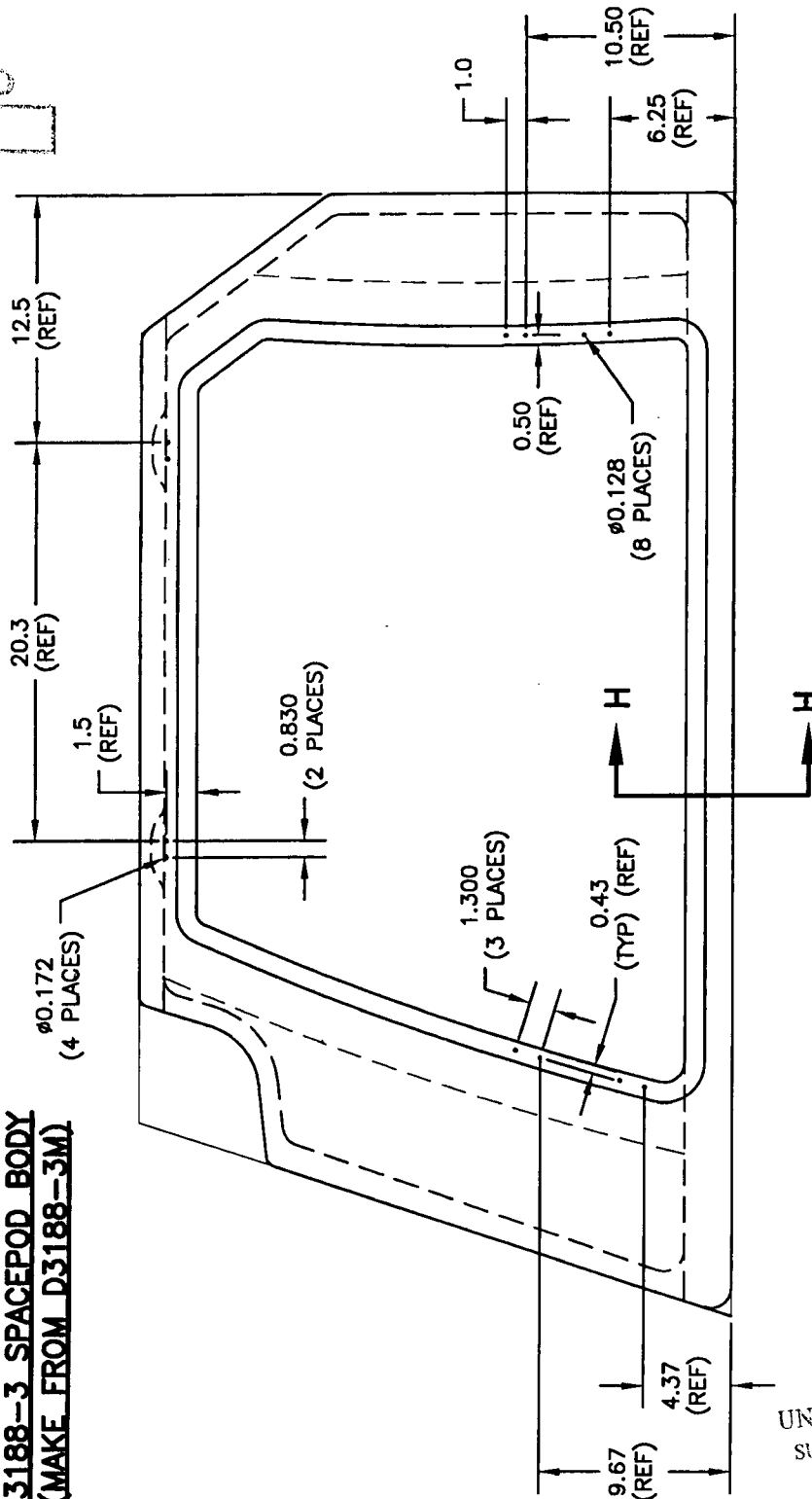
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122B

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



07.02.27



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUSPECT TO AVOID  
WITHOUT NOTICE  
NO 31122B

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

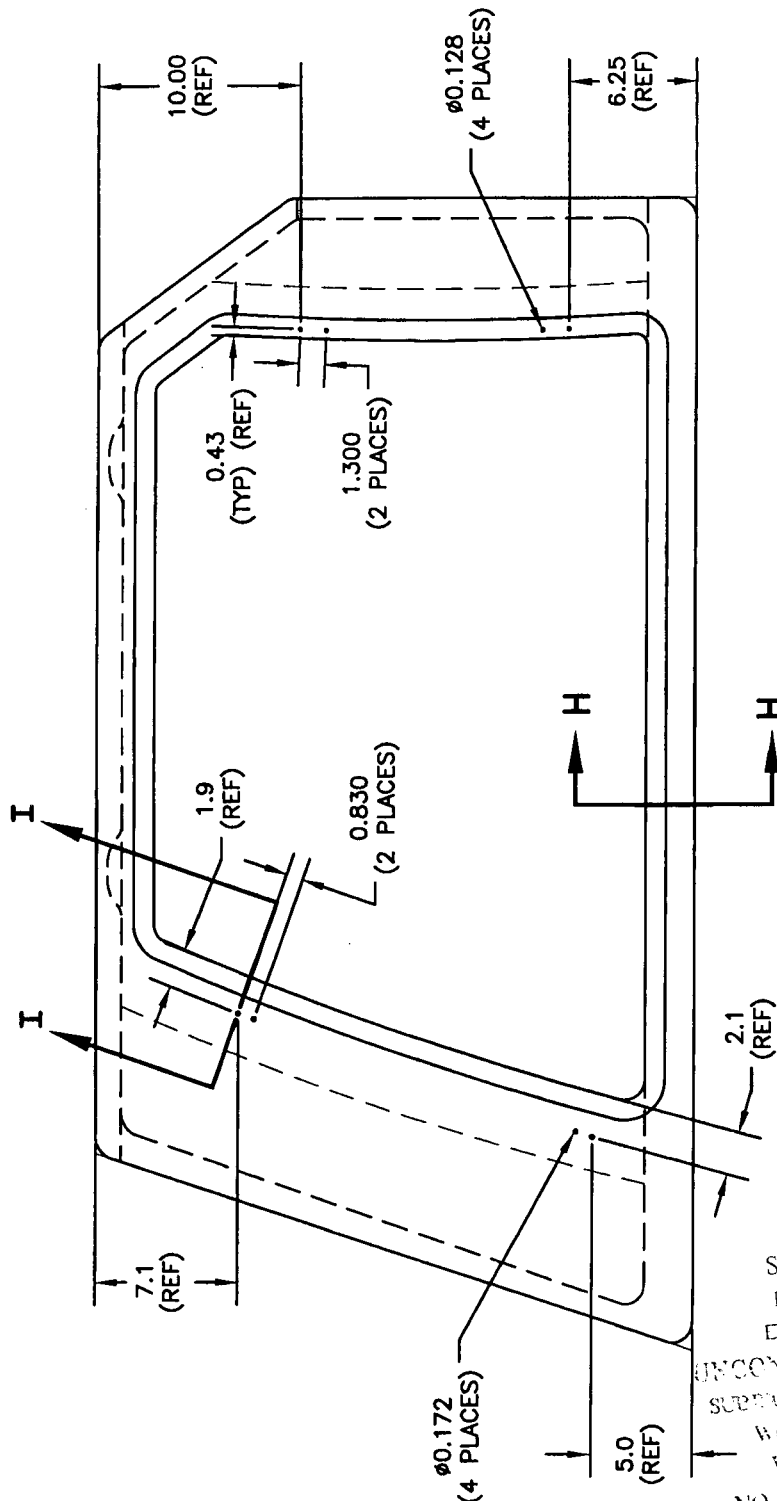
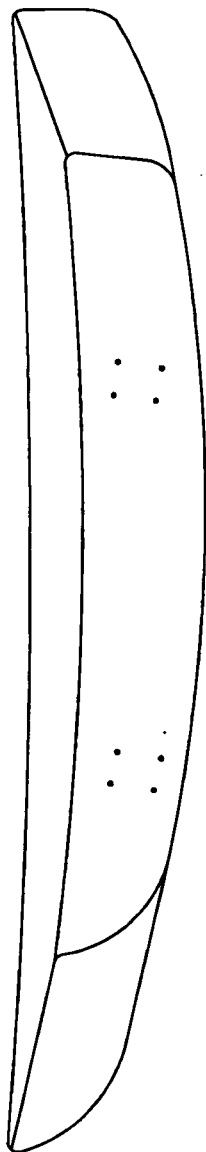


DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 8 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.22 [Signature]

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122B

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

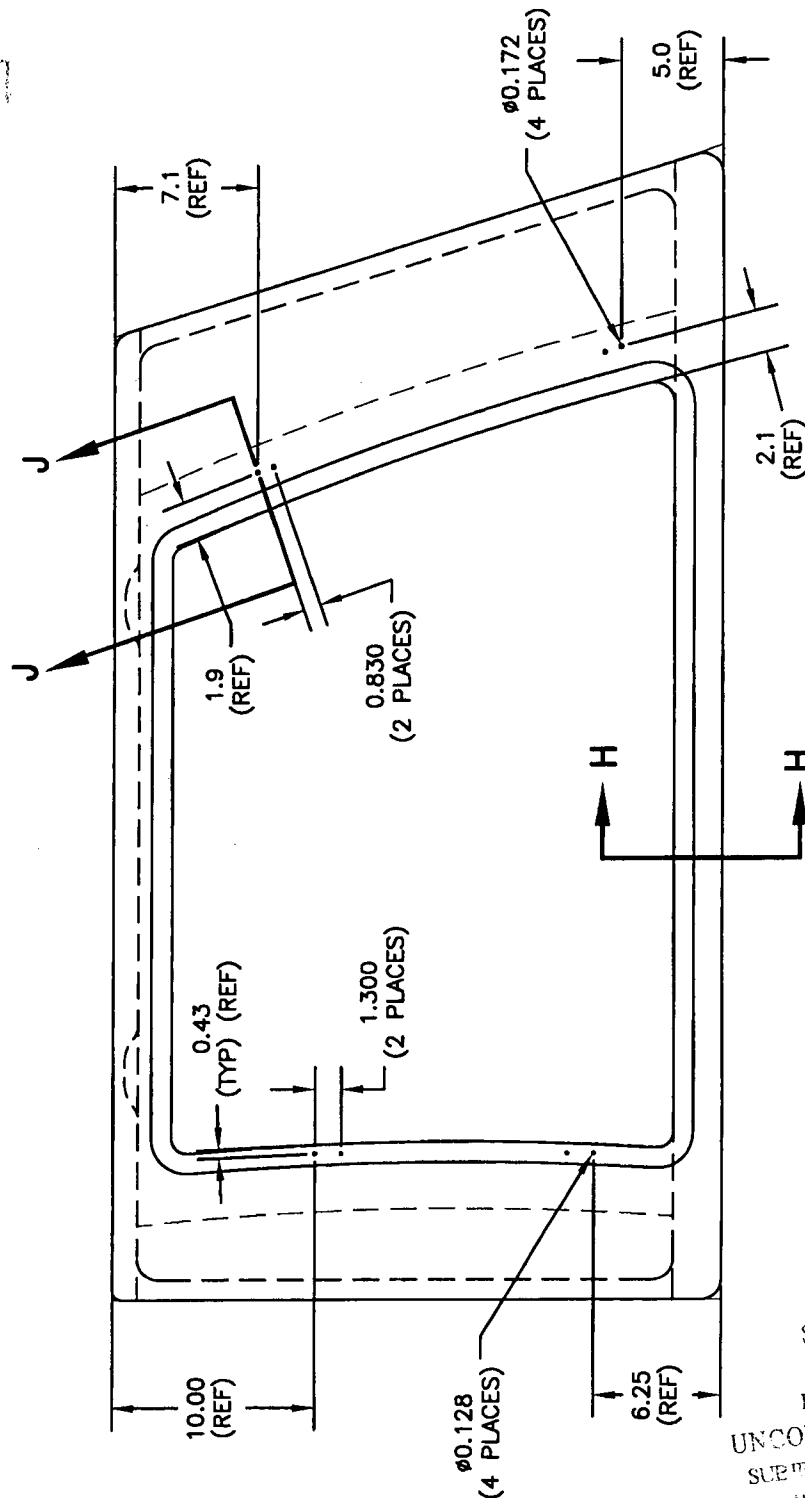
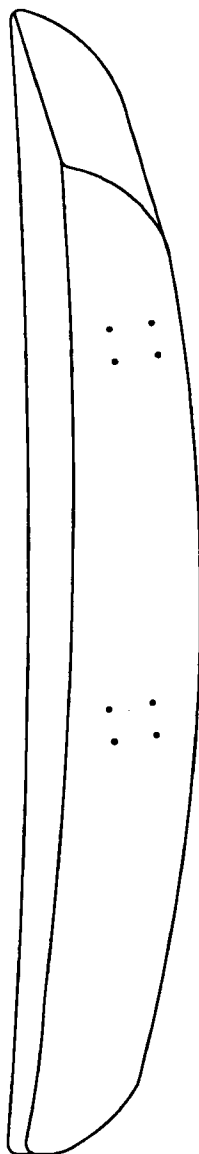
**DART**

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D3188	REV. D SHEET 9 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY	SCALE NTS	

RELEASED

07.02.27

**D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122B

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

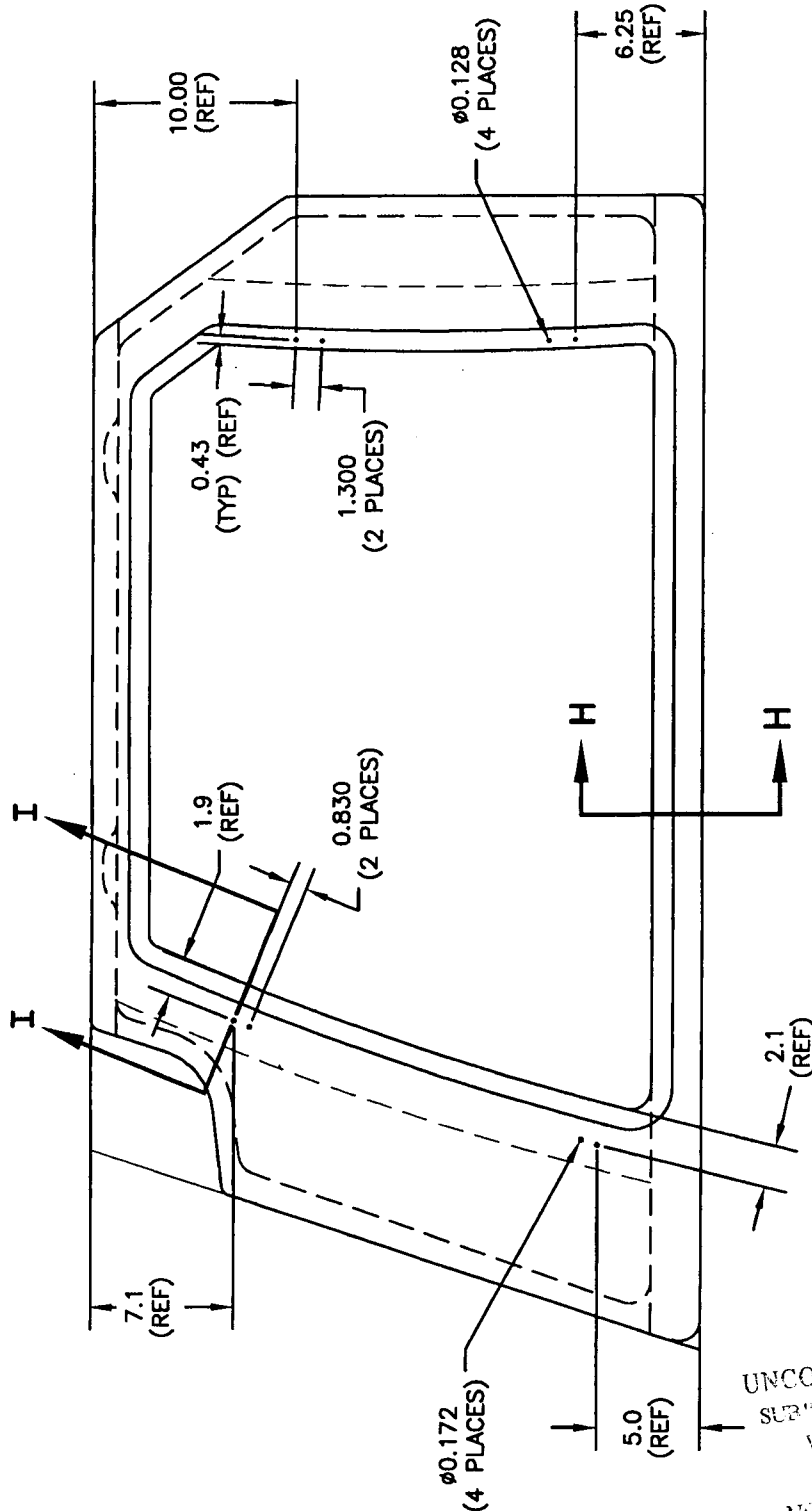
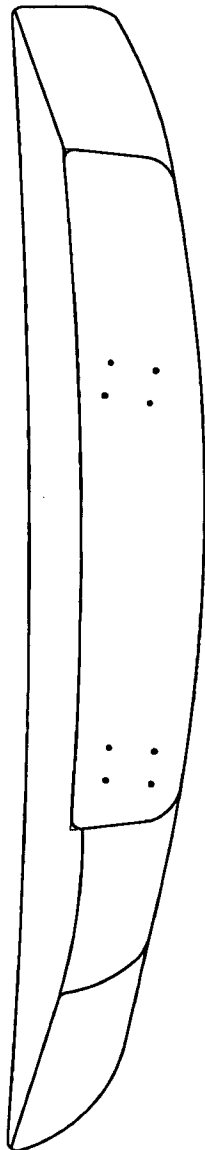
**DART**

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3188	REV. D SHEET 10 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.22

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122B

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

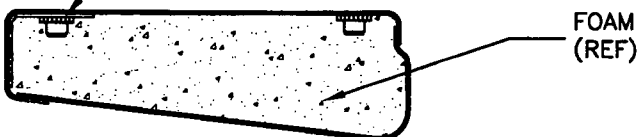
**DART**

RELEASED

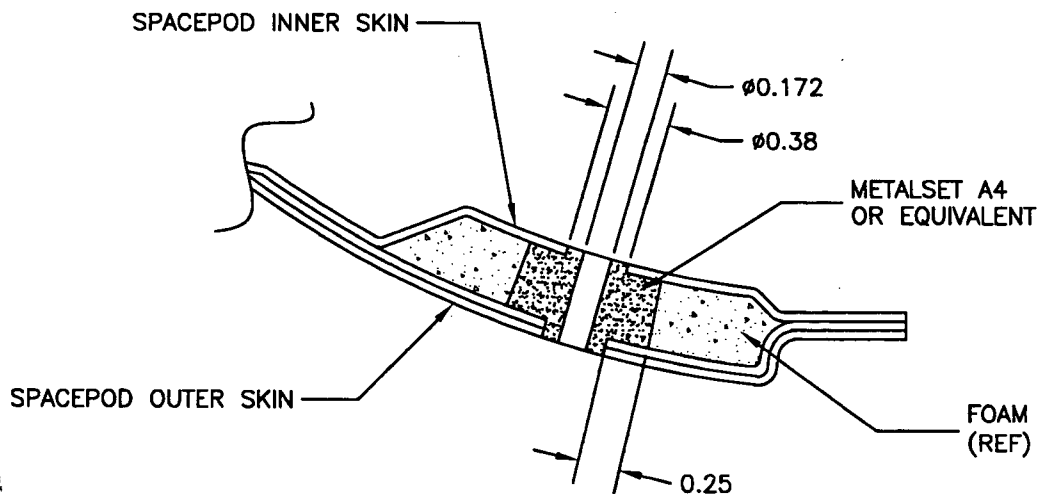
07.02.22

DESIGN	JB	DRAWN BY	CE	DART AEROSPACE LTD	REV. D
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA	
DATE	07.02.22			DRAWING NO.	SHEET 11 OF 11
				D3188	
				TITLE	SCALE
				SPACEPOD BODY	NTS

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AGREEMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 311222B

Date: Thursday, 3/8/2007 1:19:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 31122C01		
Estimate Number	: 12599		
P.O. Number	:	Part Number	: D31862M
This Issue	: 3/8/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31121C01	Material	:
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.03.08</u>		
Comment	: Est Rev: A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

*see d/o 30085*

2.0	D31862P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:19:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 31122C01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-09-18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

**DART**

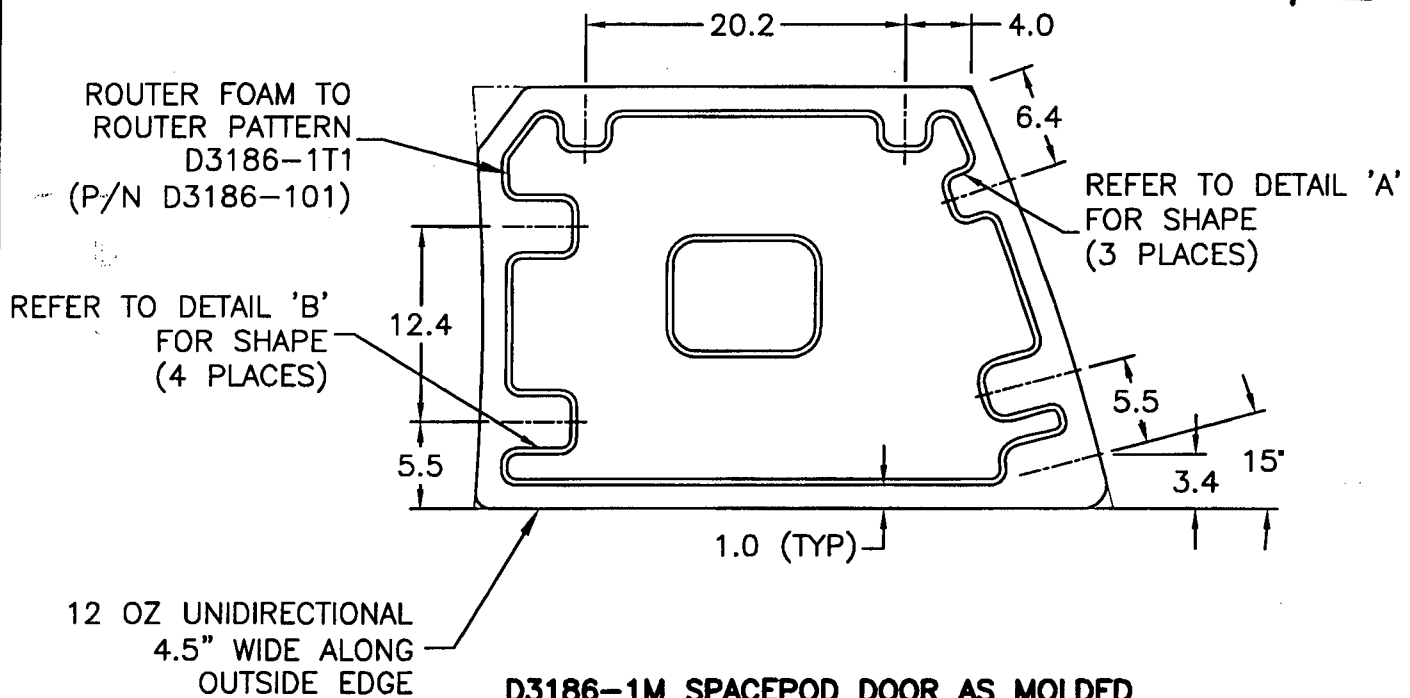
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR	SCALE NTS	
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

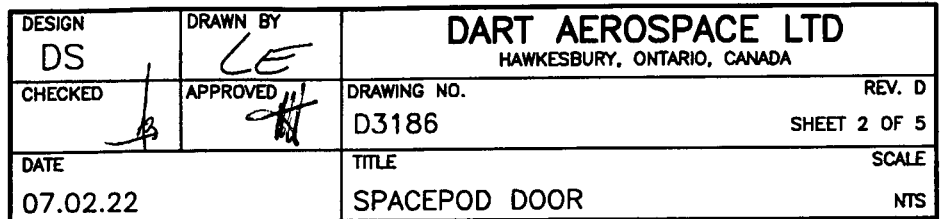
**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-SUBJECT TO A LAMINANT
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A LAMINANT  
WITHOUT THE  
WARRANTY  
NO 31122col

**Copyright © 2003 by DART AEROSPACE LTD**

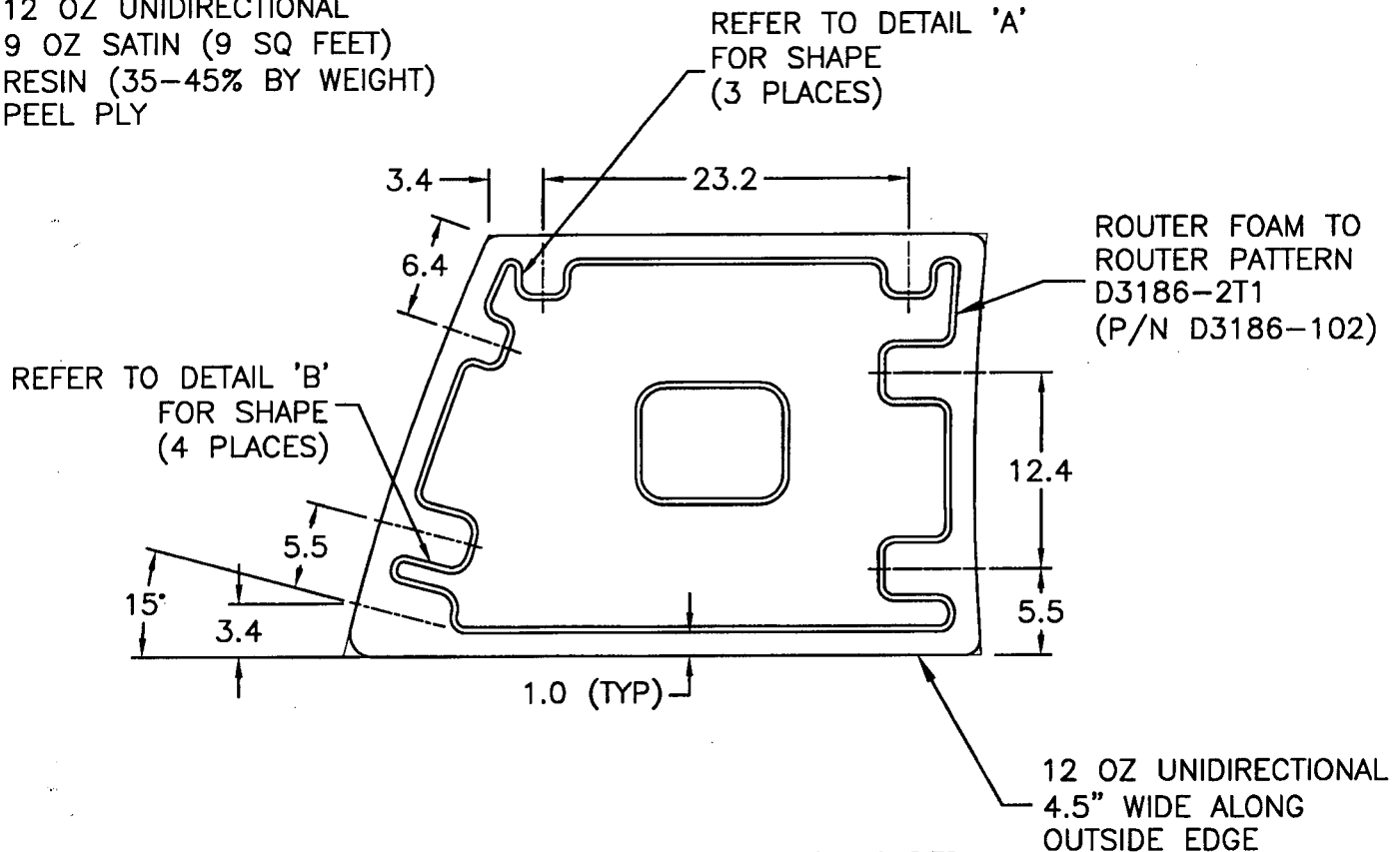
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27



- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

) S  
 CELL SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 31122co1

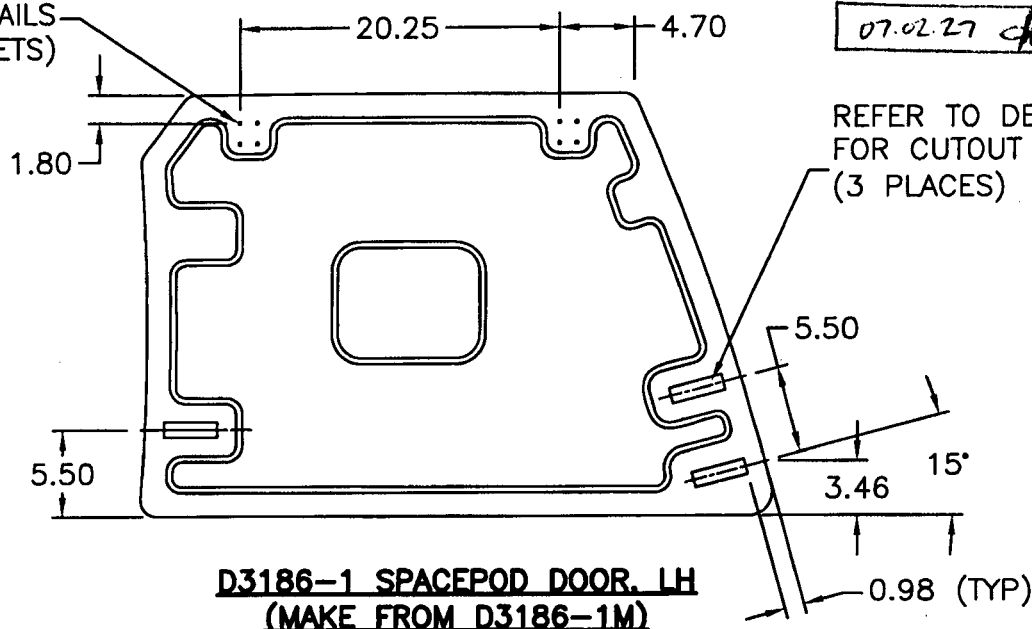
**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

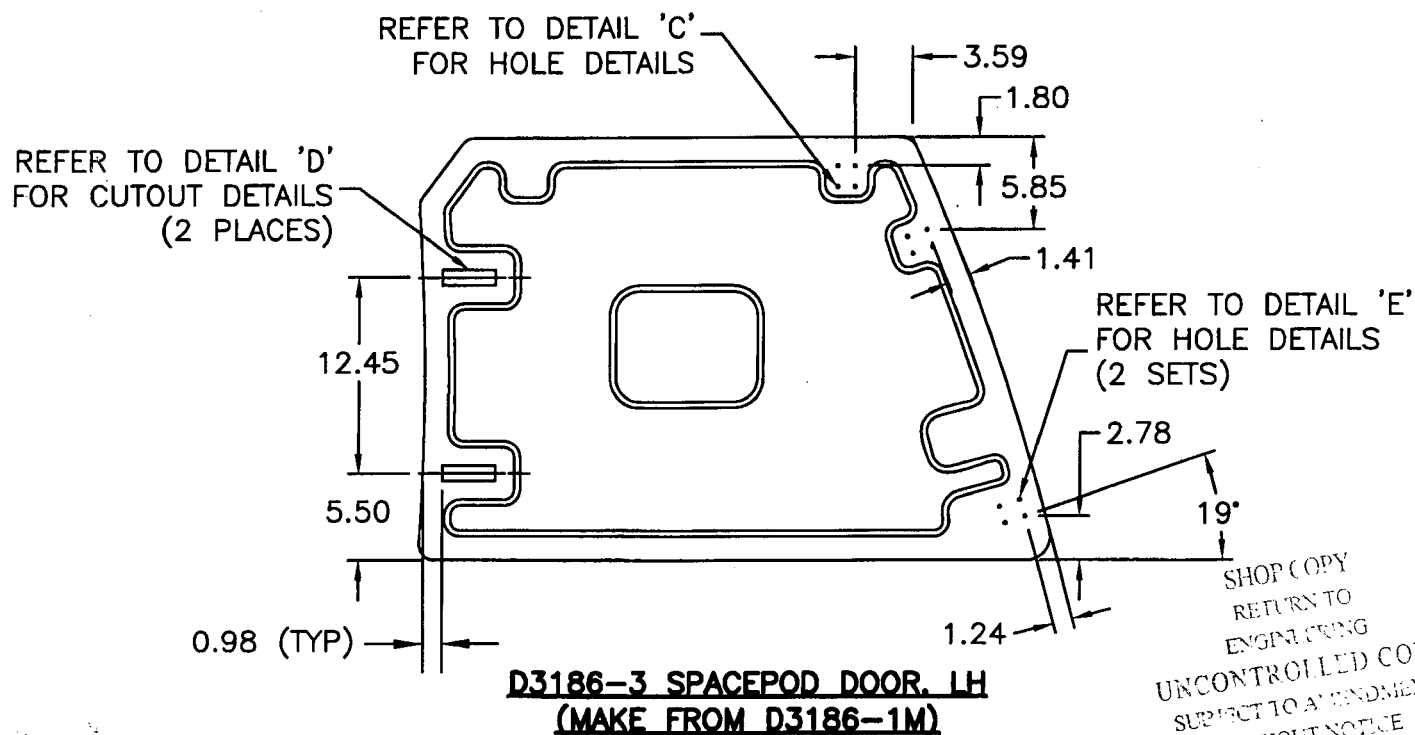
**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(3 PLACES)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122c01

Copyright © 2003 by DART AEROSPACE LTD

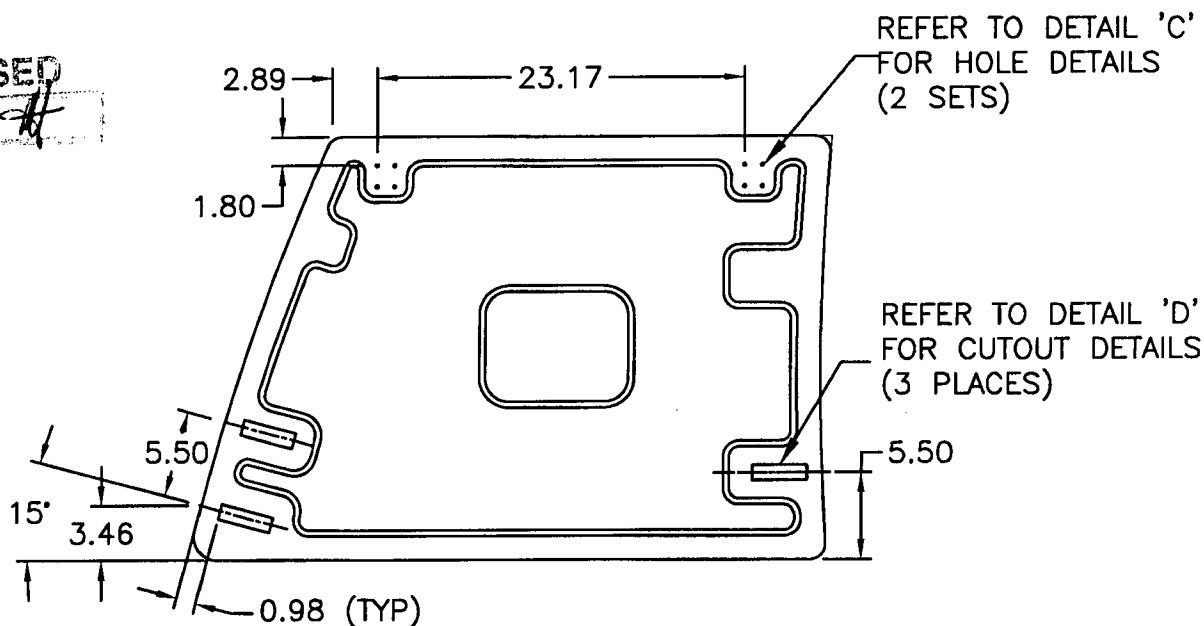
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

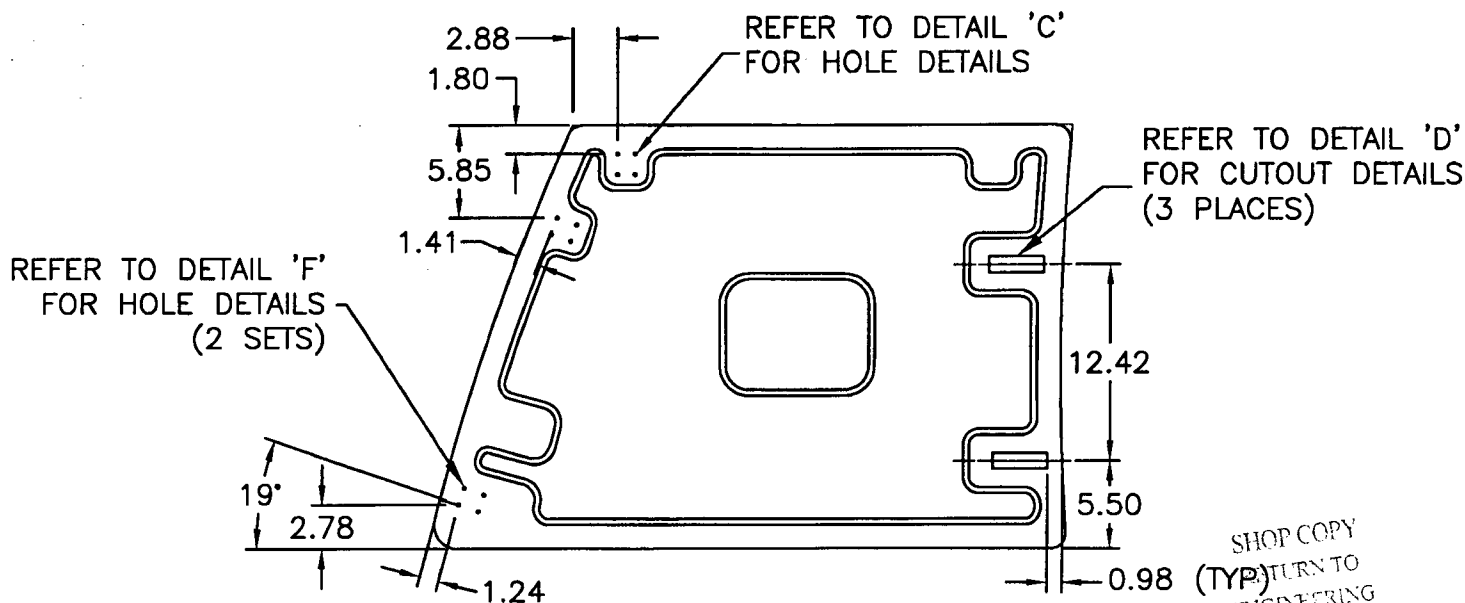
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

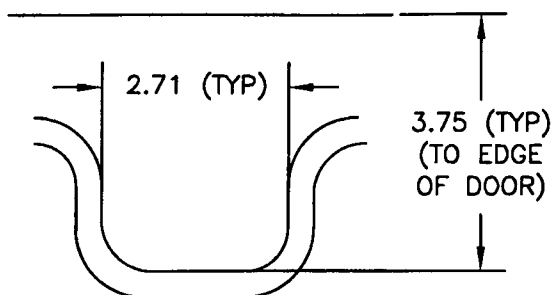
SHOP COPY  
TURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122col

Copyright © 2003 by DART AEROSPACE LTD

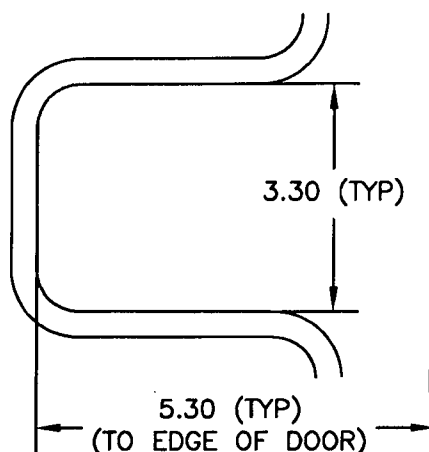
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



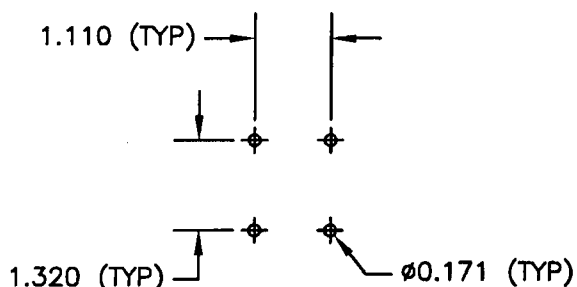
**DETAIL A**



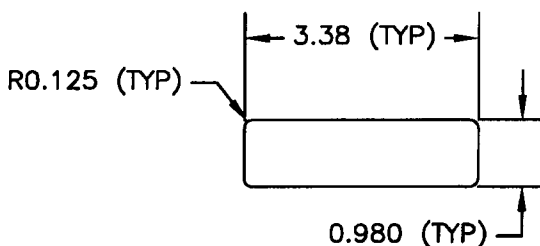
**DETAIL B**

RELEASED

07.02.27 [Signature]

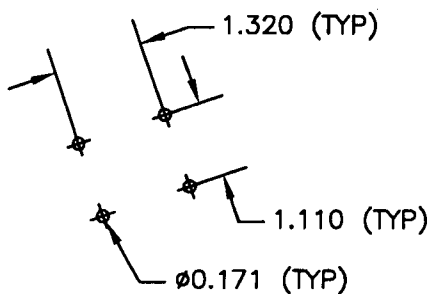


**DETAIL C**

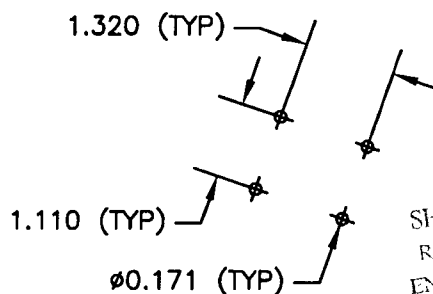


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A CHANGE  
WITHOUT NOTICE  
NO. 31122001

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Date:  
User:Thursday, 12/21/2006 12:55:30 PM  
Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SPACEPOD BODY RH
<b>Job Number</b> :	30090	<b>Part Number</b> :	D31882M
<b>Estimate Number</b> :	12596	<b>Drawing Number</b> :	D3188 REV <i>AC LE 07-01.18</i>
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	12/21/2006	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	<i>BC LE 07.01.18</i>
<b>First Issue</b> :	11	<b>Material</b> :	
<b>Previous Run</b> :	30089	<b>Due Date</b> :	2/15/2007
<b>Written By</b> :	<i>061221</i>	<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A New issue ecn882 06-11-30 EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Ship To Delastek

8 D2213 Spacer Batch: *B 30049*

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: *02771*  
Description: D3188-2M BODY  
SHIP: D2213 Spacers  
Supplier: Delastek  
Conformity Certificate and Process sheet required  
Ship 2 Items from Previous steps

*C 20612122 0*

3.0	D31882P	Spacepod Body
-----	---------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   2   Date: 07/09/17

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:55:30 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 30090

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

*ml 07/08/15*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*ml 07/08/15*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*12/29/19*

Job Completion



*U 07-09-18*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN		DRAWN BY		DART AEROSPACE LTD	
JB		CE		HAMKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
DATE	06.12.13			D3188	SHEET 1 OF 11
				TITLE	SCALE
				SPACEPOD BODY	NTS
A	03.04.03			NEW ISSUE	
B	06.10.06			UPDATED DWG TO MATCH PRODUCT	
				ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13			REMOVED D0600-XXX LABELS	

**GENERAL NOTES:**

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

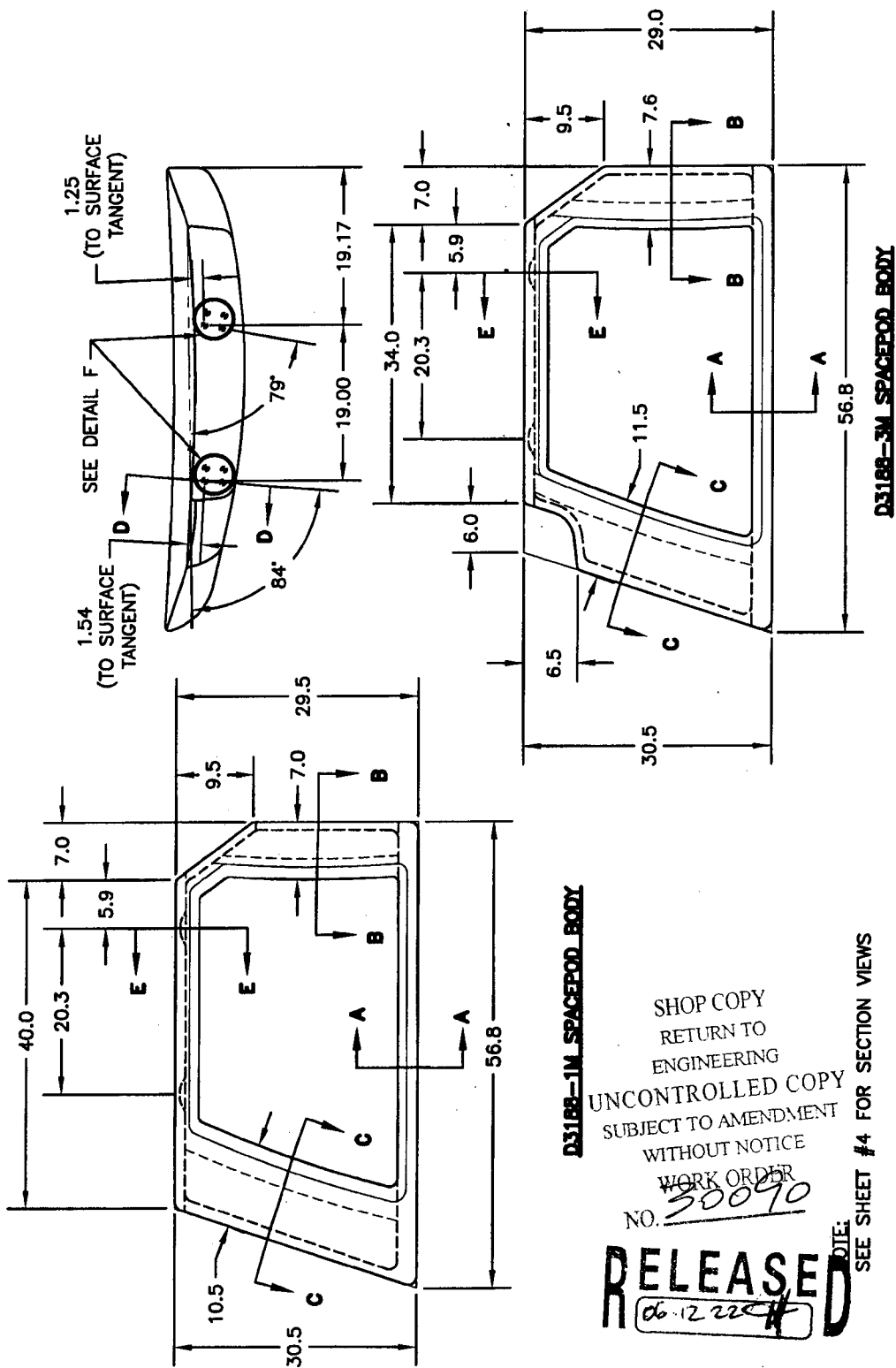
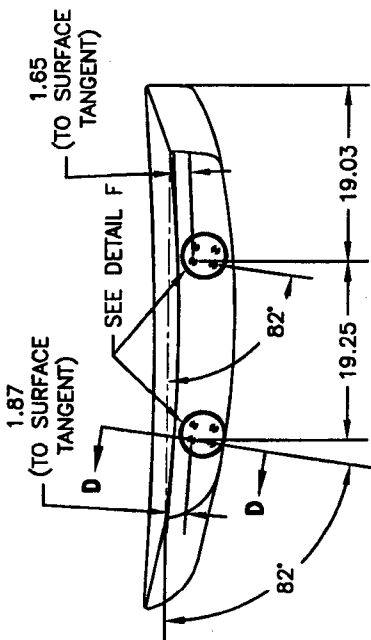
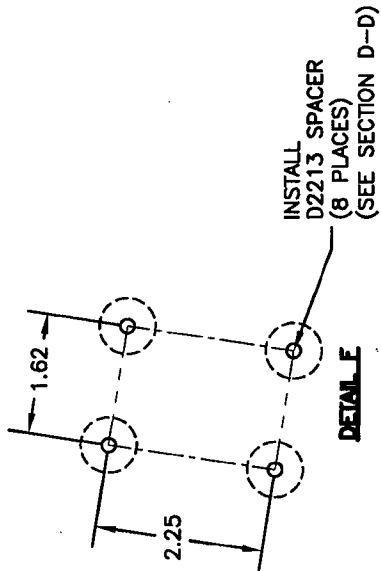
5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
06.12.22

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 30090  
WORK ORDER



DESIGN <b>JB</b>	DRAWN BY <b>LE</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. C SHEET 2 OF 11
DATE <b>06.12.13</b>		TITLE <b>SPACEPOD BODY</b>	SCALE <b>NTS</b>



D3188-1M SPACEPOD BODY

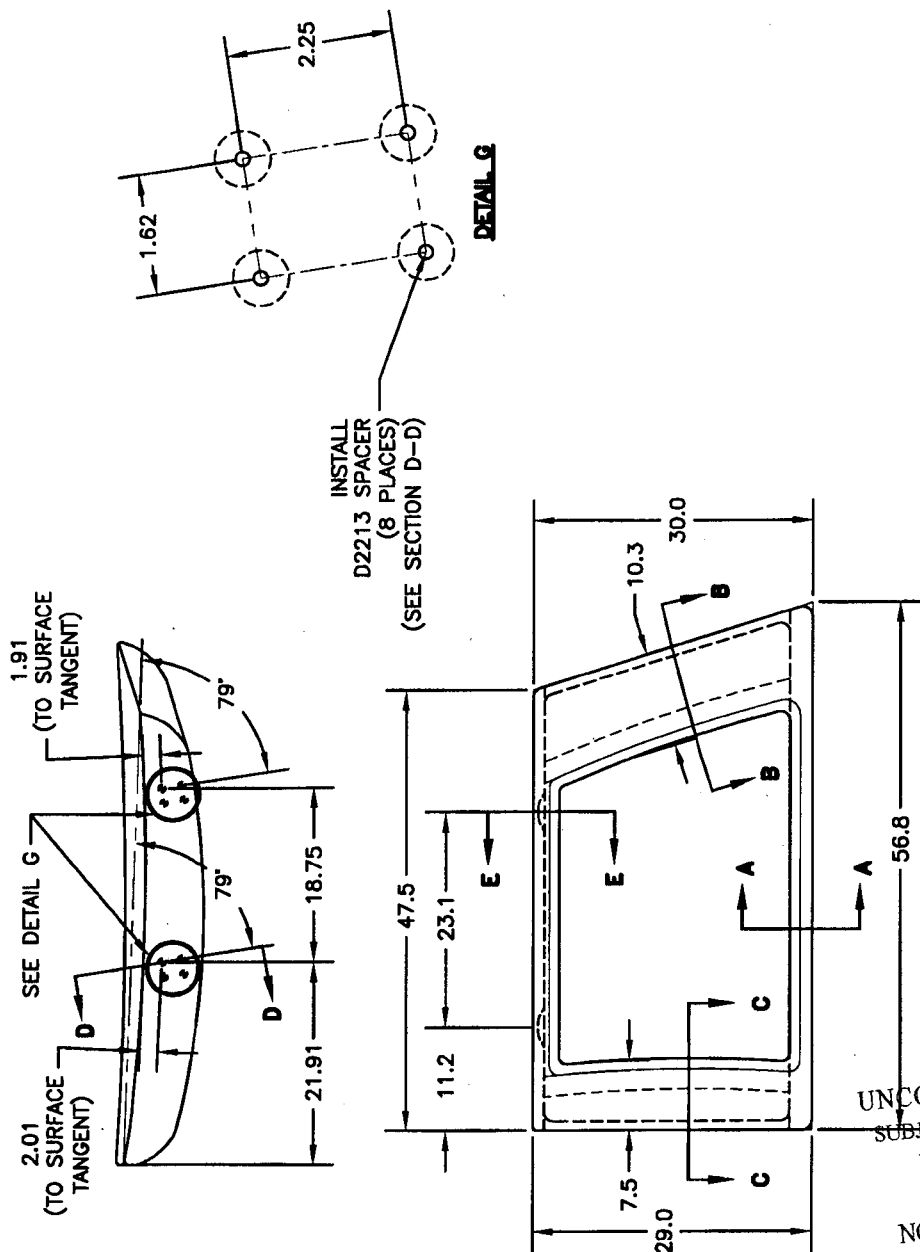
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090  
RELEASED  
06-12-2013  
DATE: SEE SHEET #4 FOR SECTION VIEWS

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <b>JB</b>	DRAWN BY <b>LE</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3188</b>	REV. C SHEET 3 OF 11
DATE <b>06.12.13</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS



STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090

RELEASED  
06.12.22

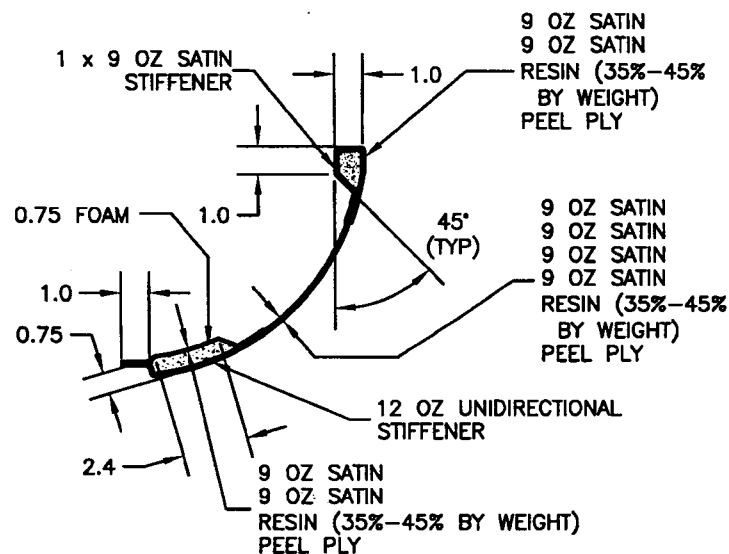
NOTE:  
SEE SHEET #4 FOR SECTION VIEWS

Copyright © 2003 by DART AEROSPACE LTD

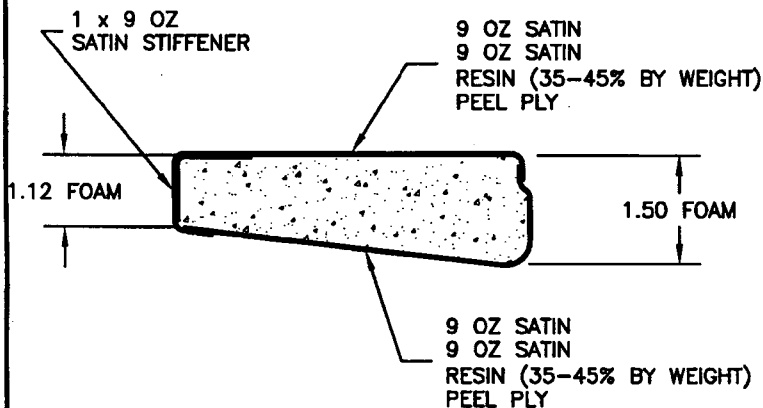
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

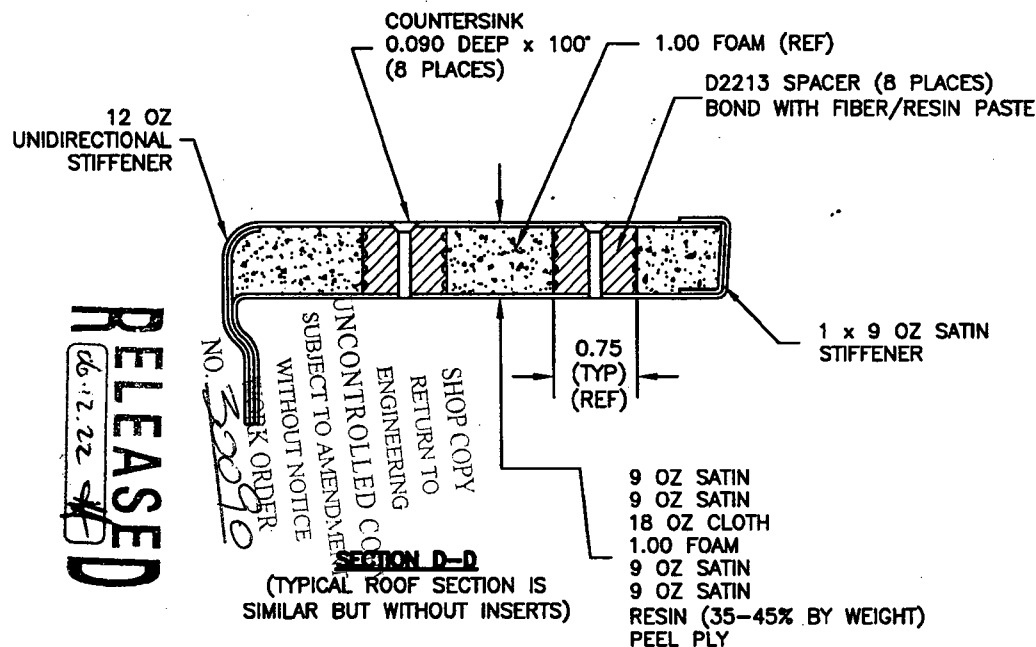
DESIGN	JB	DRAWN BY	CE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3188
DATE	06.12.13	TITLE	SPACEPOD BODY	REV. C
				SHEET 4 OF 11
				SCALE NTS



**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)

**SECTION E-E**  
(2 PLACES PER POD)

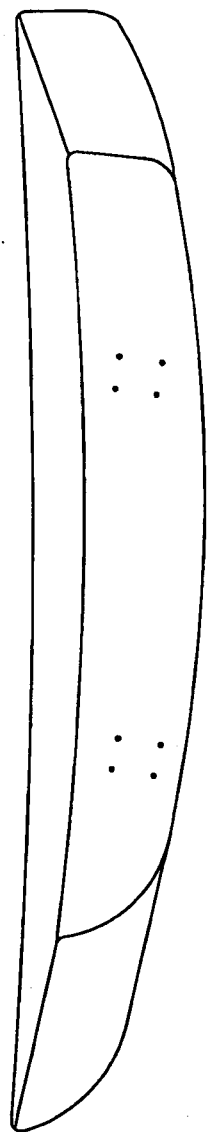
**RELEASED**  
06.12.22



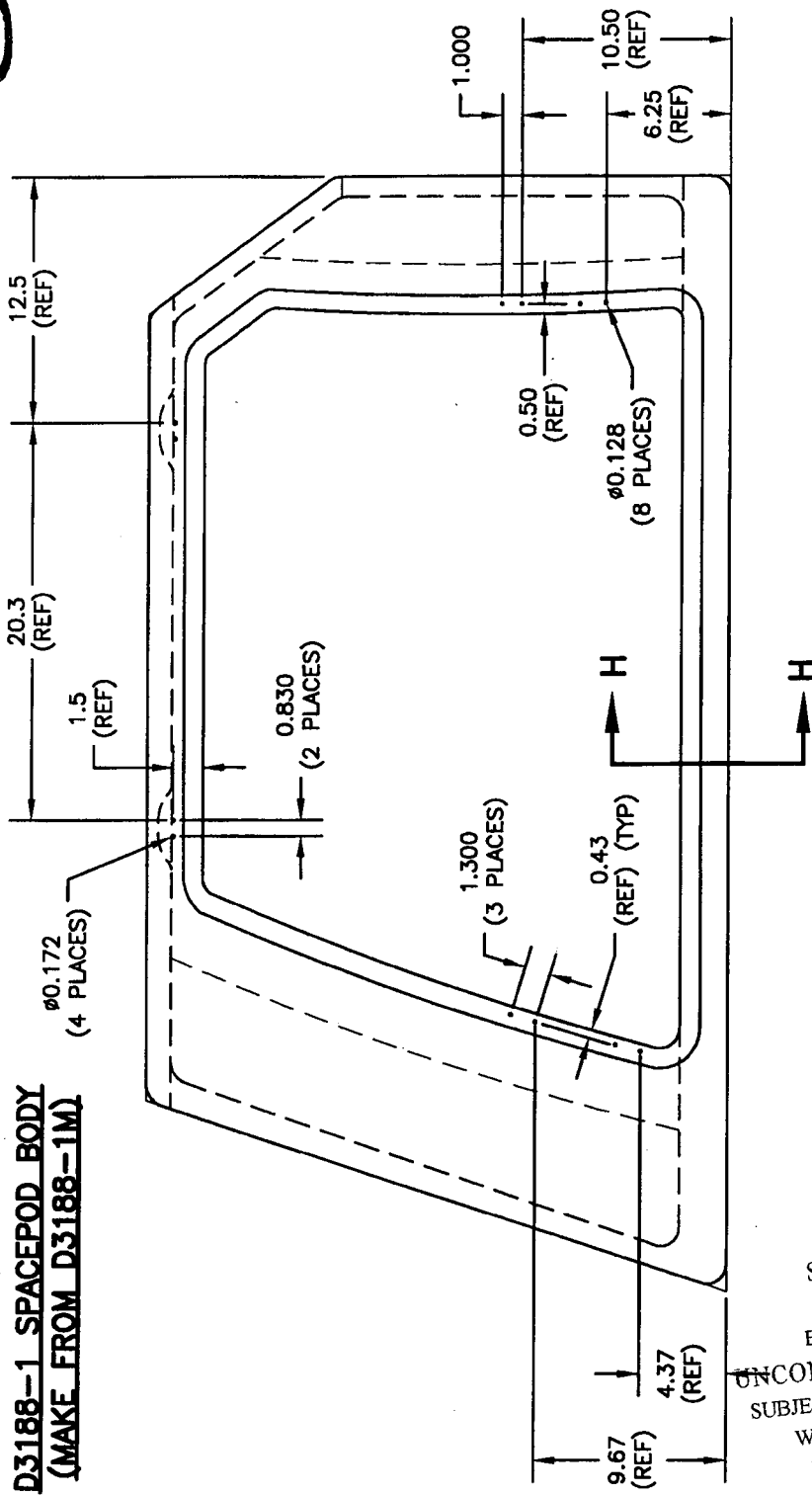


DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 5 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22



**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090

Copyright © 2003 by DART AEROSPACE LTD

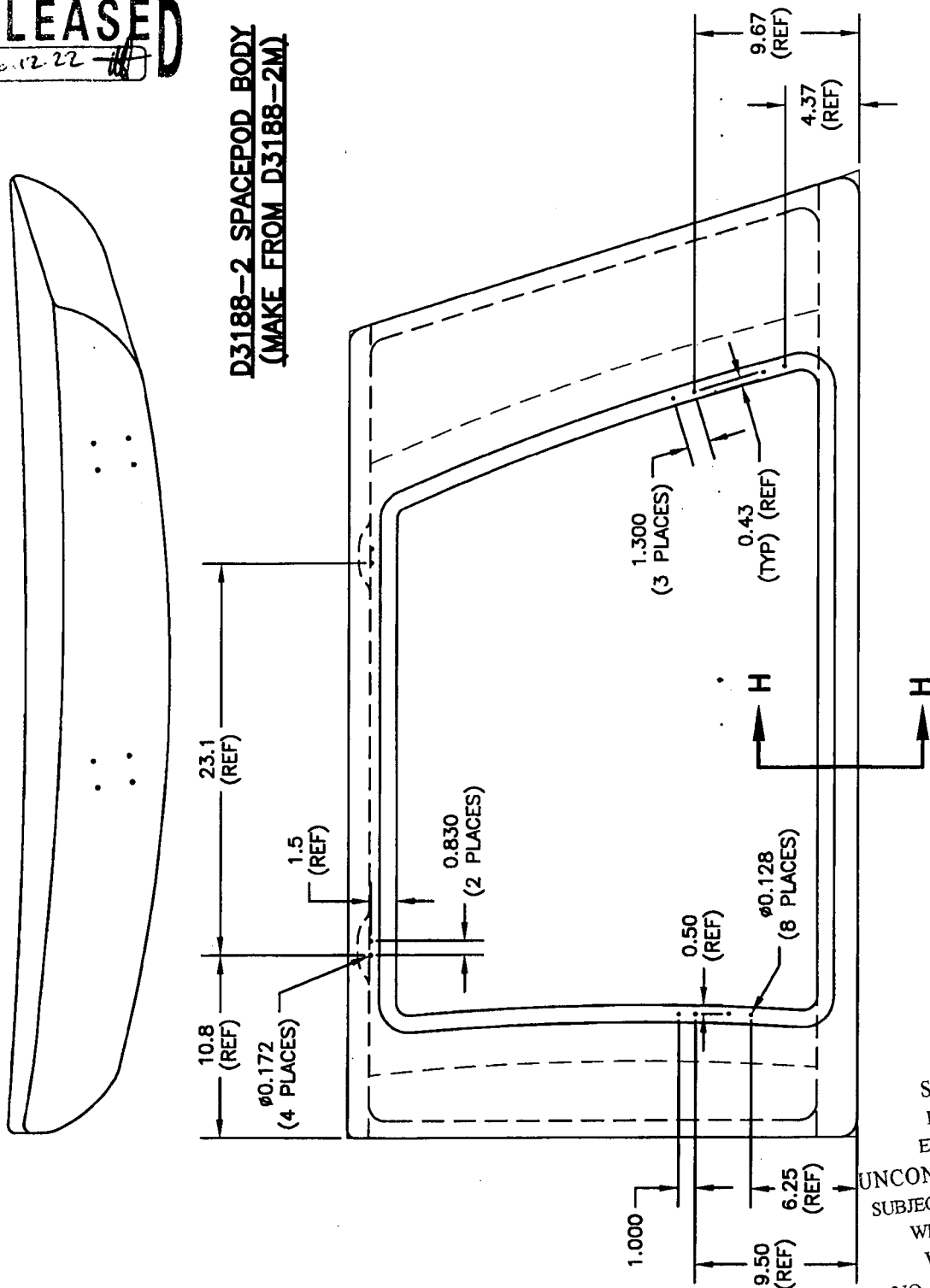
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 6 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22

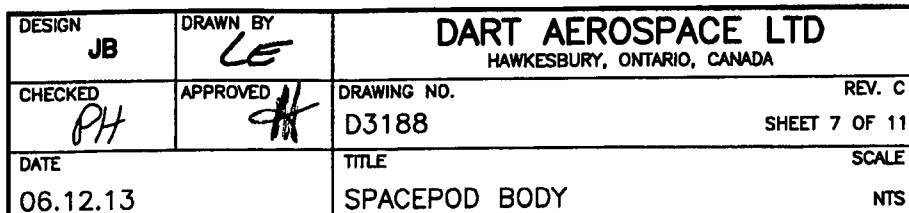
**D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



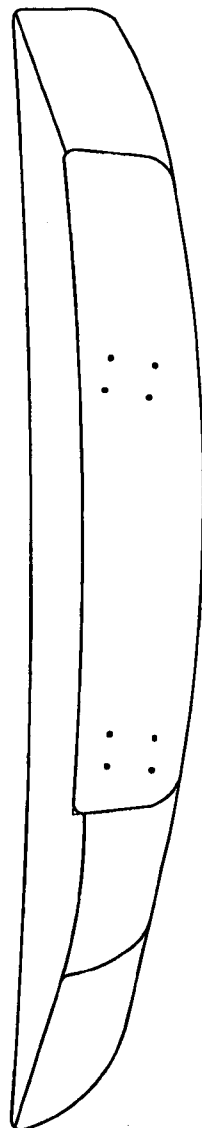
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090

Copyright © 2003 by DART AEROSPACE LTD

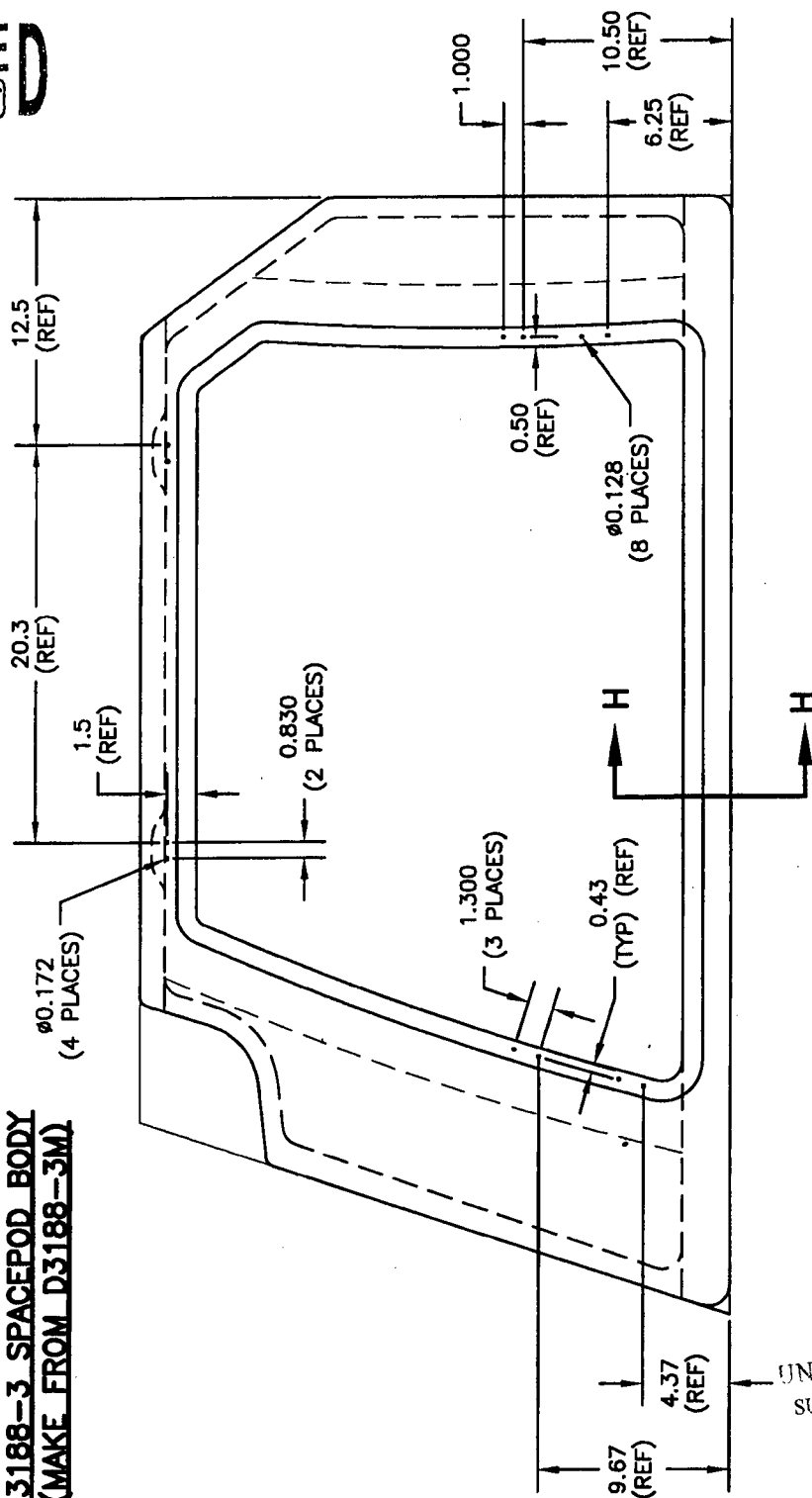
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



RELEASED  
06-12-22



D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090

**Copyright © 2003 by DART AEROSPACE LTD**

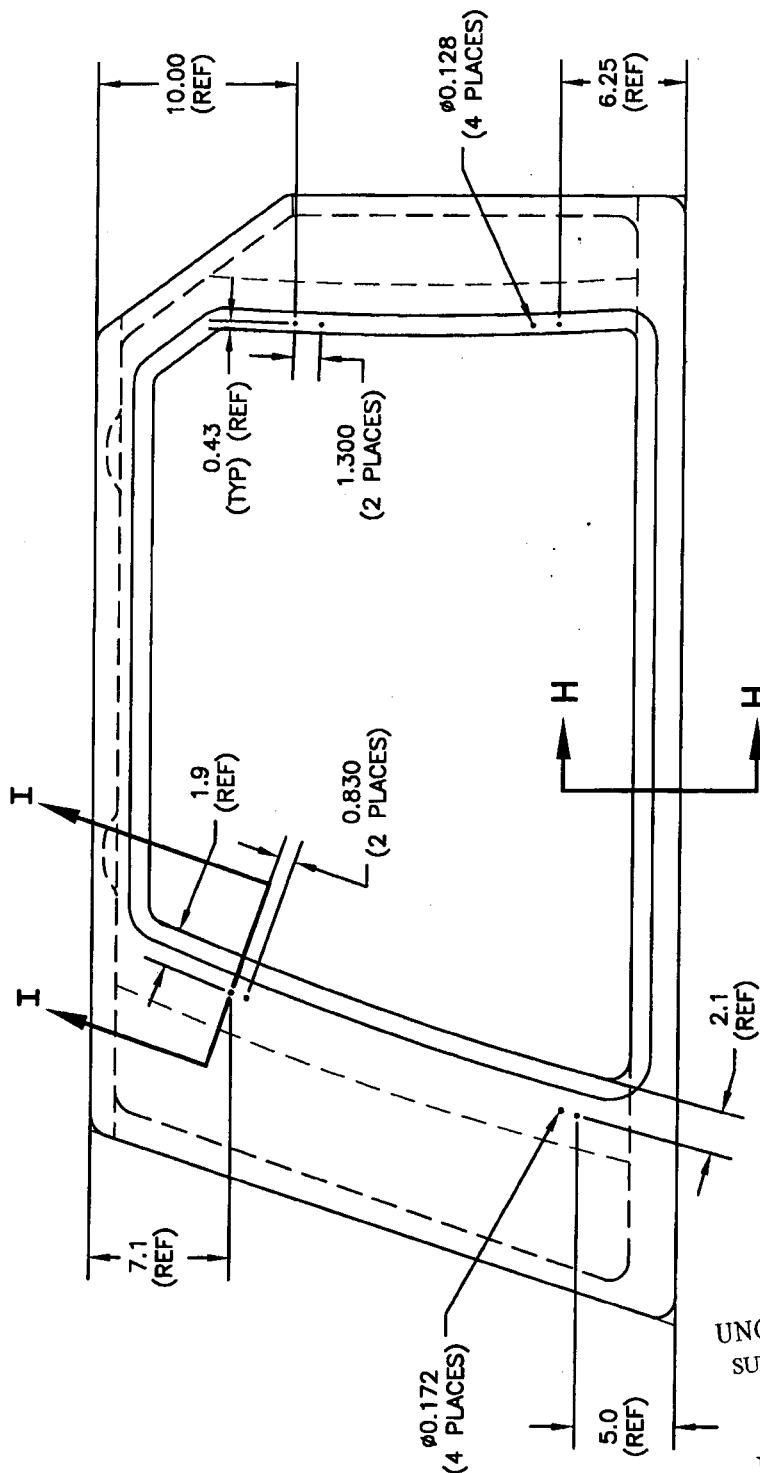
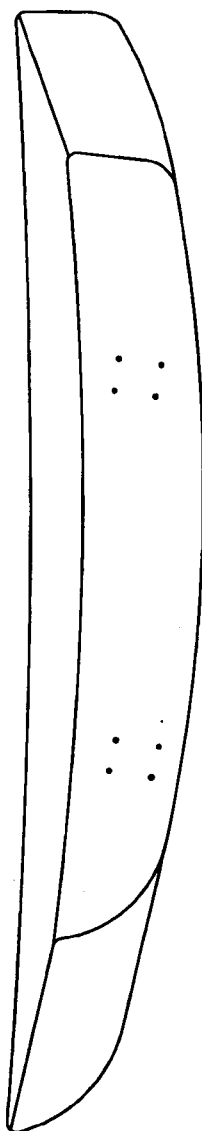
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 8 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090

Copyright © 2003 by DART AEROSPACE LTD

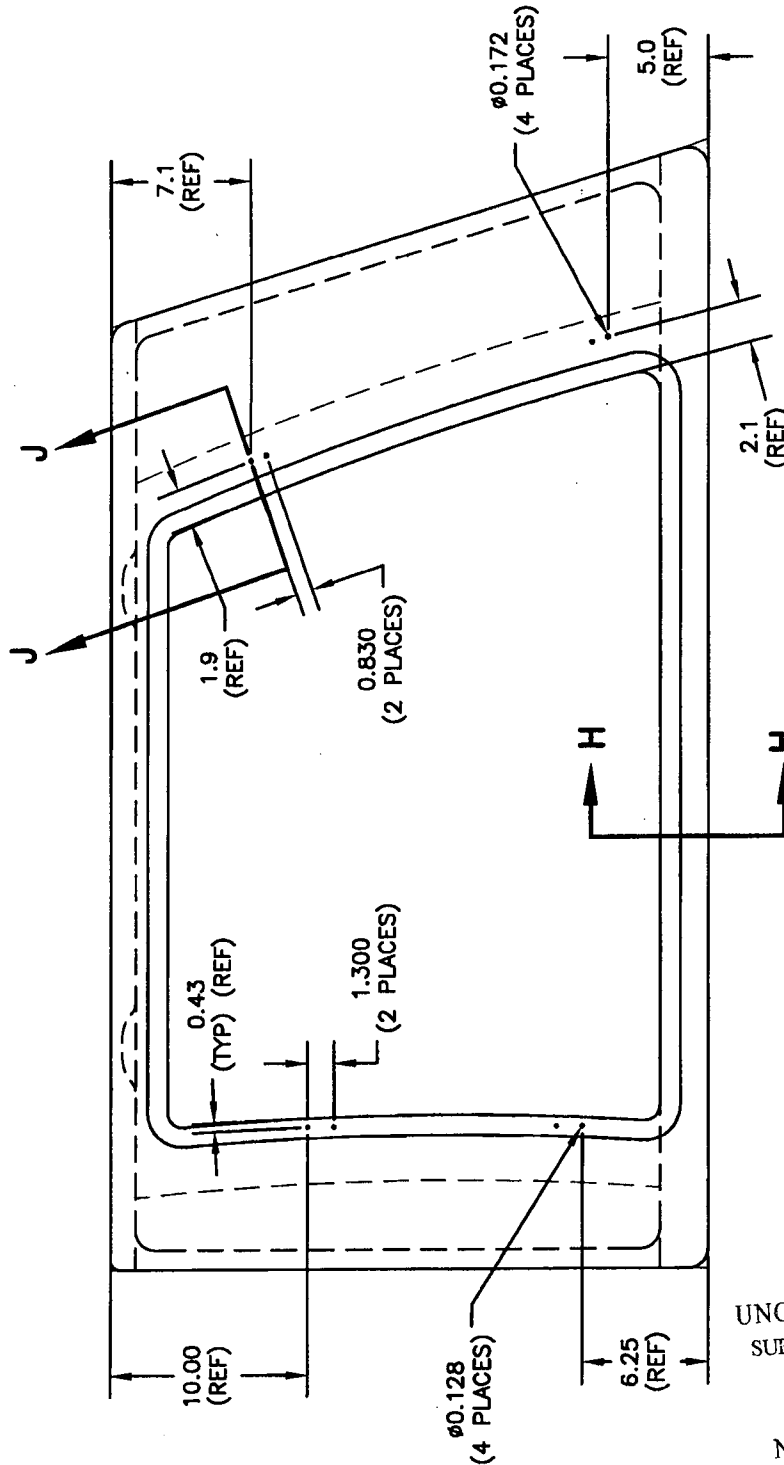
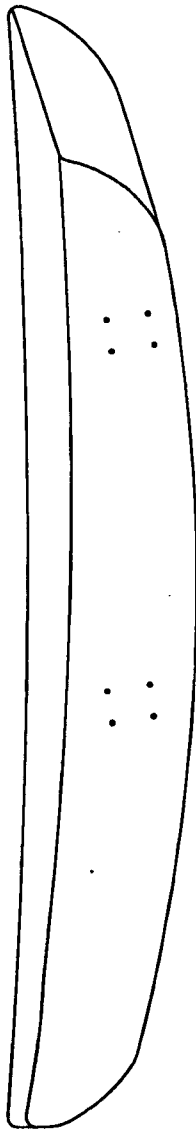
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 9 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22 [Signature]

D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)



NOTES:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090

Copyright © 2003 by DART AEROSPACE LTD

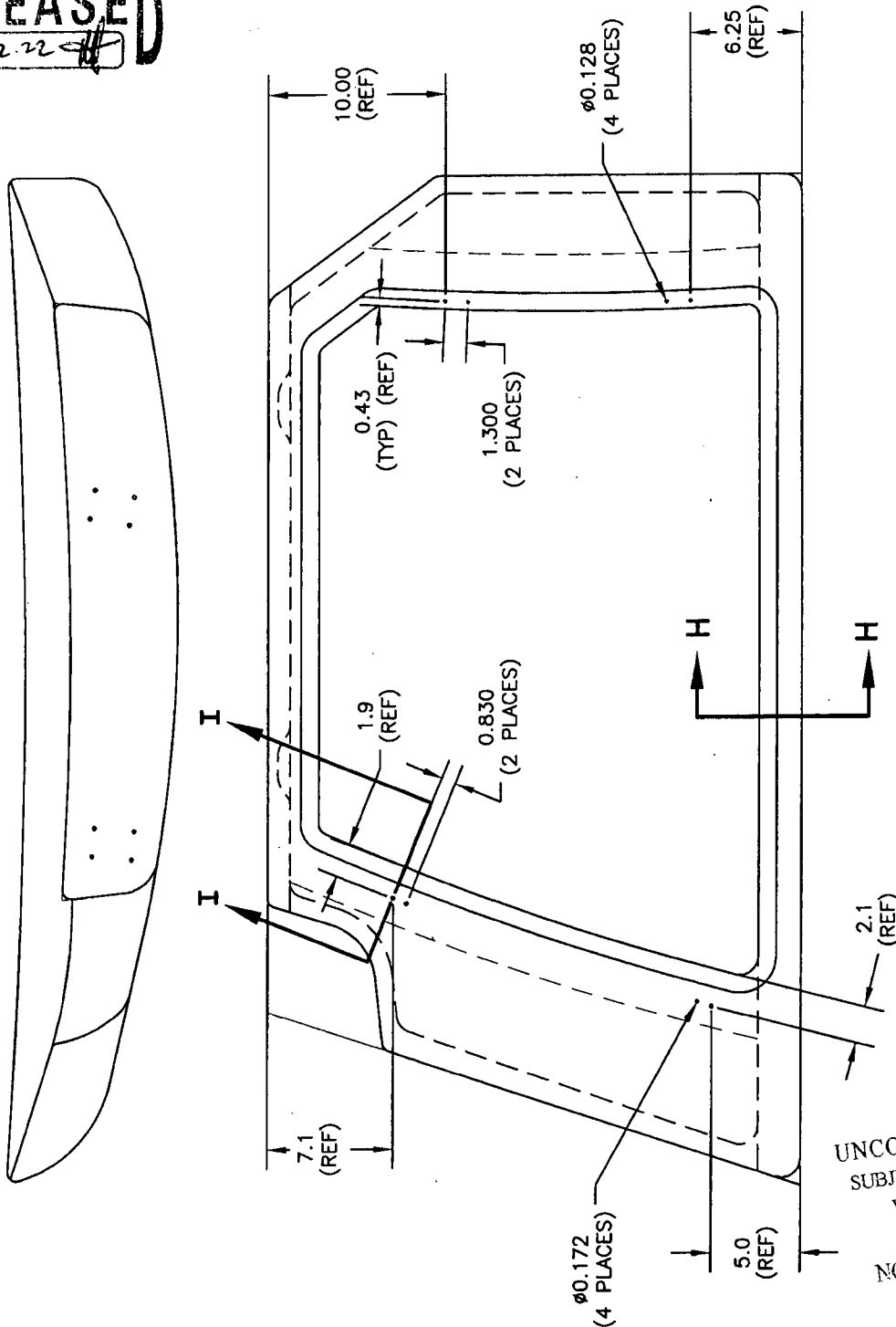
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 10 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
a.r.r.

D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)



NOTE:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30090

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <b>JB</b>	DRAWN BY <b>LE</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. C SHEET 11 OF 11
DATE <b>06.12.13</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

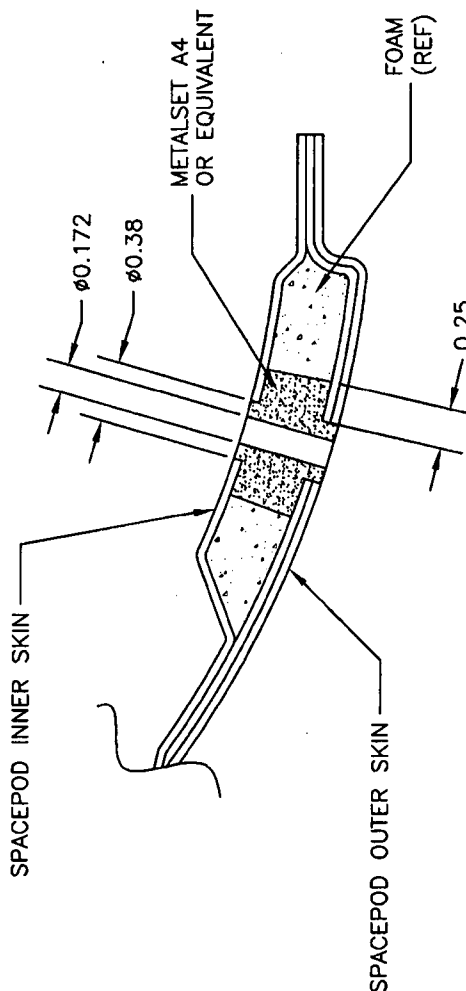
RELEASED  
06.12.22

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **30090**

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Thursday, 3/8/2007 1:19:05 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 31122C		
Estimate Number	: 11099		
P.O. Number	: <i>N/A</i>	Part Number	: D31862
This Issue	: 3/8/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3186 REV.D
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 31121C	Drawing Revision	: D
		Material	: <i>N/A</i>
Written By	:	Due Date	: 4/15/2007
Checked & Approved By	: <i>07.03.08</i>	Qty:	1 Um: Each
Comment	: Est Rev: A New Issue 05-11-29 JLM est rev B rev D dwg EC 07.03.07		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	31122C01	SPACEPOD DOOR RH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR RH

2.0	SMALL FAB 1 <i>w/o 30085</i>	SMALL & MEDIUM FAB RESOURCE 1
-----	------------------------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-2 detail)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07-09-18*



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

**DART**

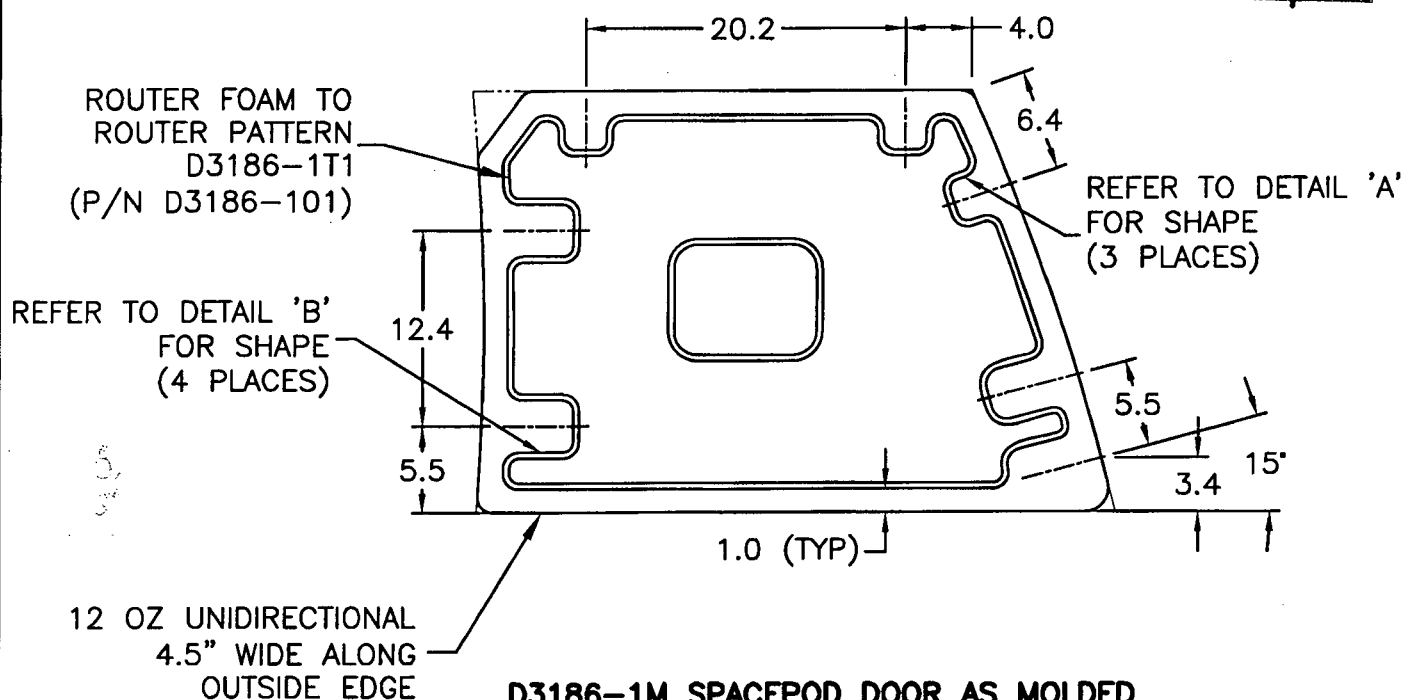
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECEL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122C

**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

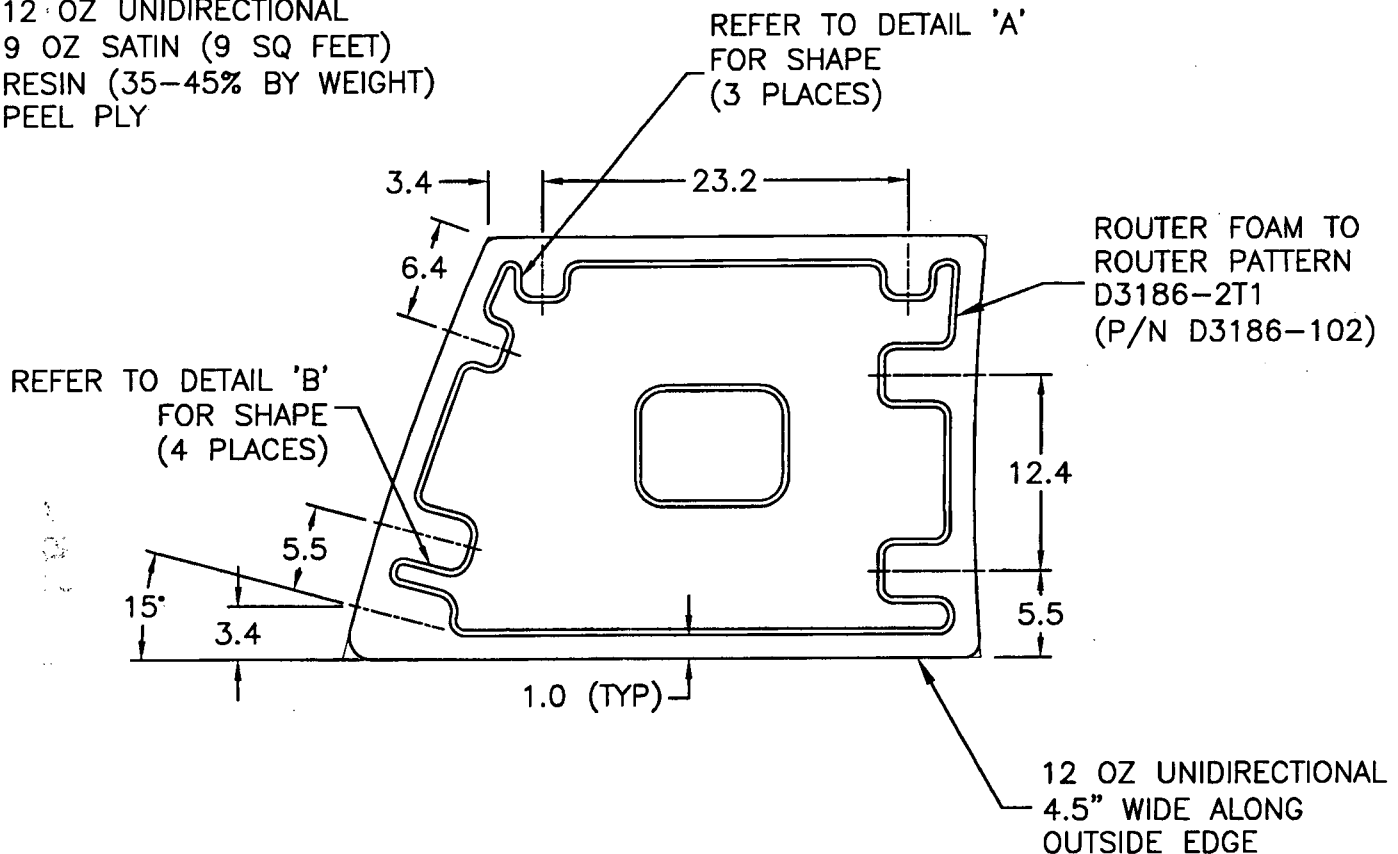
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.22 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122C

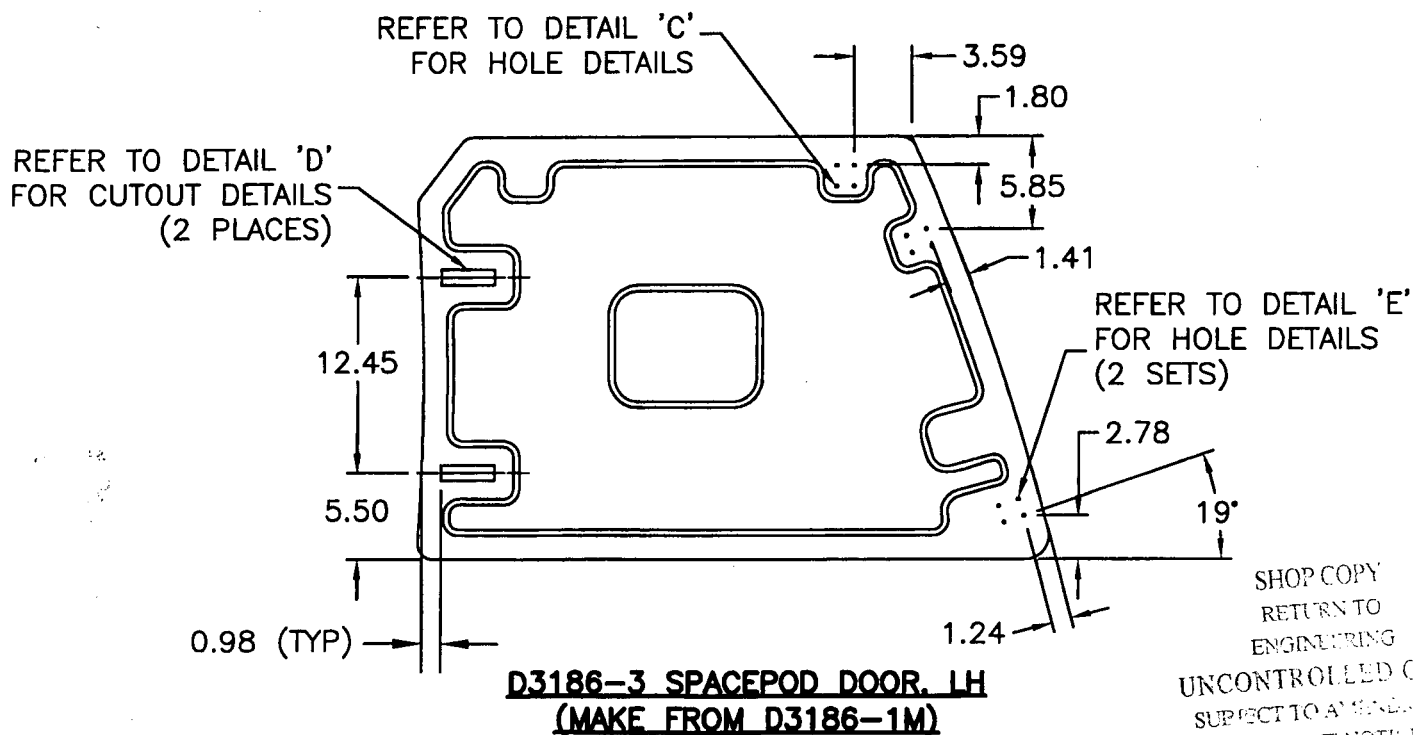
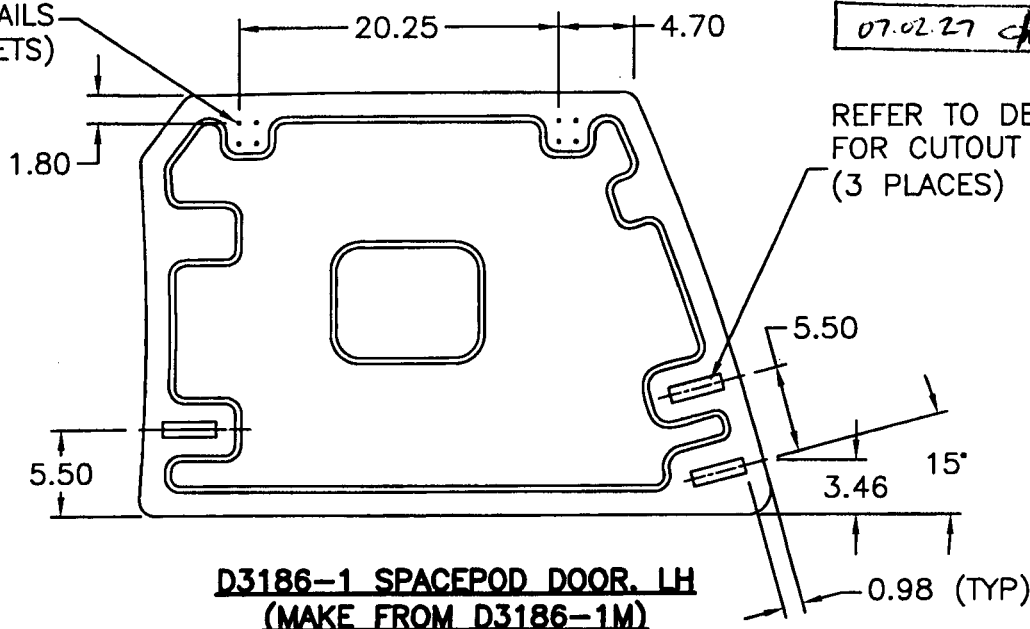
**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A CHANGE  
WITHOUT NOTICE  
WORK ORDER  
NO. **31122C**

Copyright © 2003 by DART AEROSPACE LTD

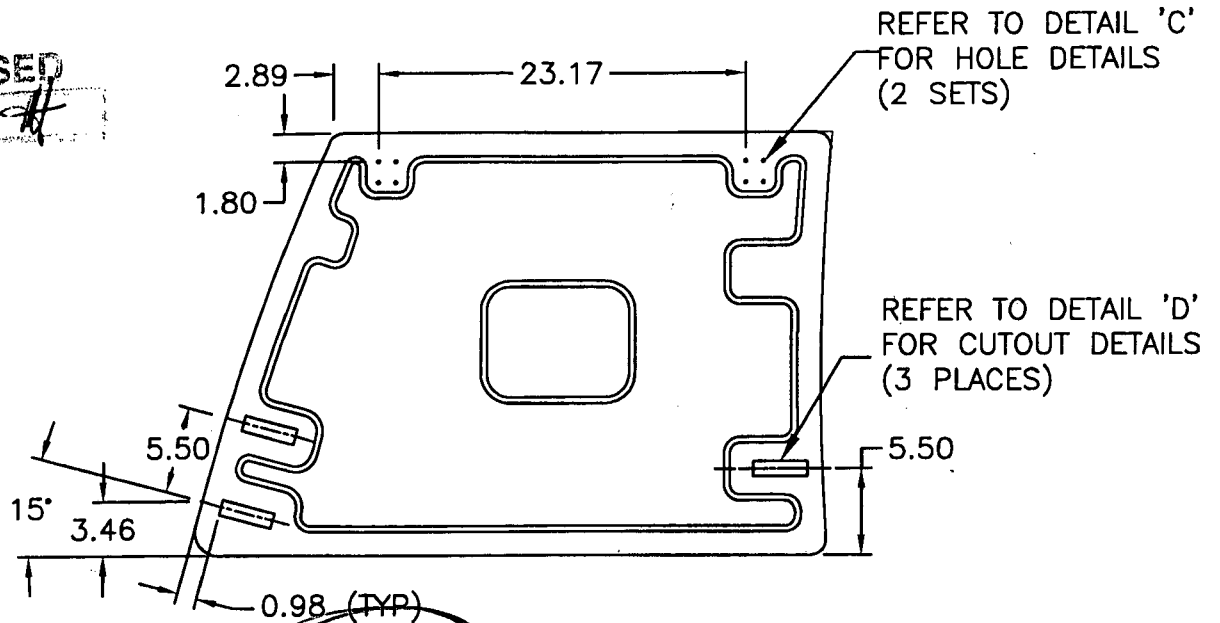
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

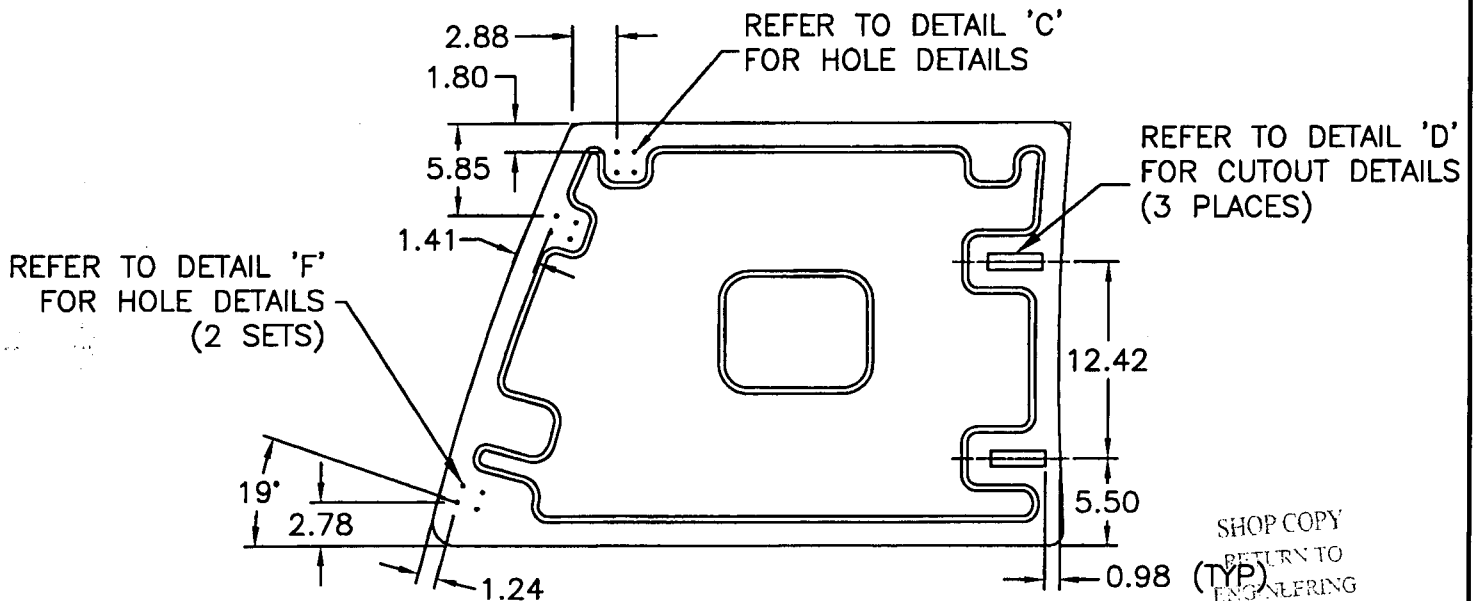
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

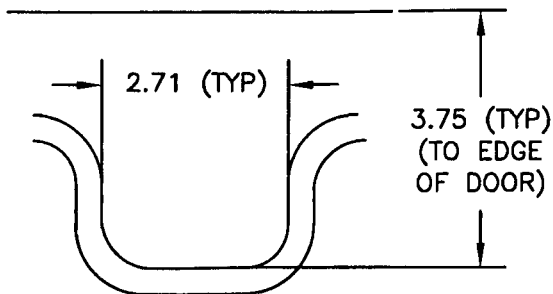
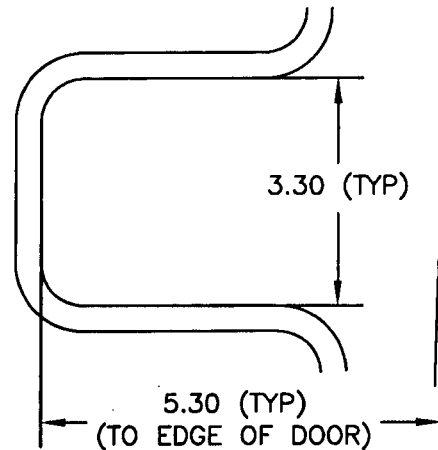
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122C

Copyright © 2003 by DART AEROSPACE LTD

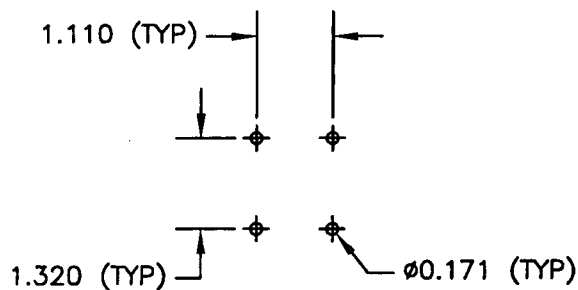
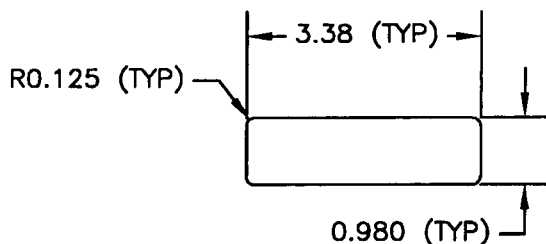
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

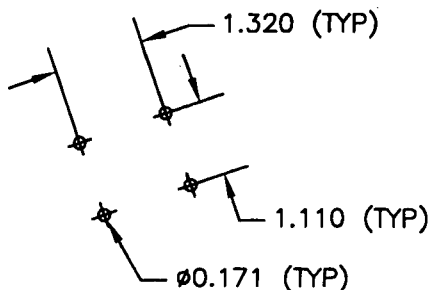
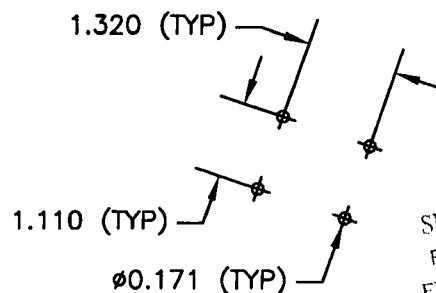
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****DETAIL B****RELEASED**

07.02.27 [Signature]

**DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F****NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31122C

**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Thursday, 12/21/2006 12:55:12 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD DOOR RH  
 Job Number : 30085  
 Estimate Number : 12599  
 P.O. Number : N/A Part Number : D31862M  
 This Issue : 12/21/2006 S.O. No. : N/A Drawing Number : D3186 REV *EC UE 07-01-18*  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : *EC UE 07-01-18*  
 Previous Run : 30084 Material : N/A  
 Due Date : 2/15/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : *06-12-21*  
 Comment : Est Rev:A New Issue 06-12-04 ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



## Comment: PURCHASING

Issue P/O: *2771*  
 Description: D3186-2M Door  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 3 Items from Previous steps

*06-12-22*

2.0 D31862P Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0 PACKAGING 1 PACKAGING RESOURCE #1



## Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

*7/8/13 SP*

4.0 QC6 DIMENSIONAL CHECK



## Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

*1705-14*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



## Comment: PACKAGING RESOURCE #1

Identify and Stock  
 Location: *GA*

*07/08/15*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 12/21/2006 12:55:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 30085

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/21/06 (1)

Job Completion



12/21/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

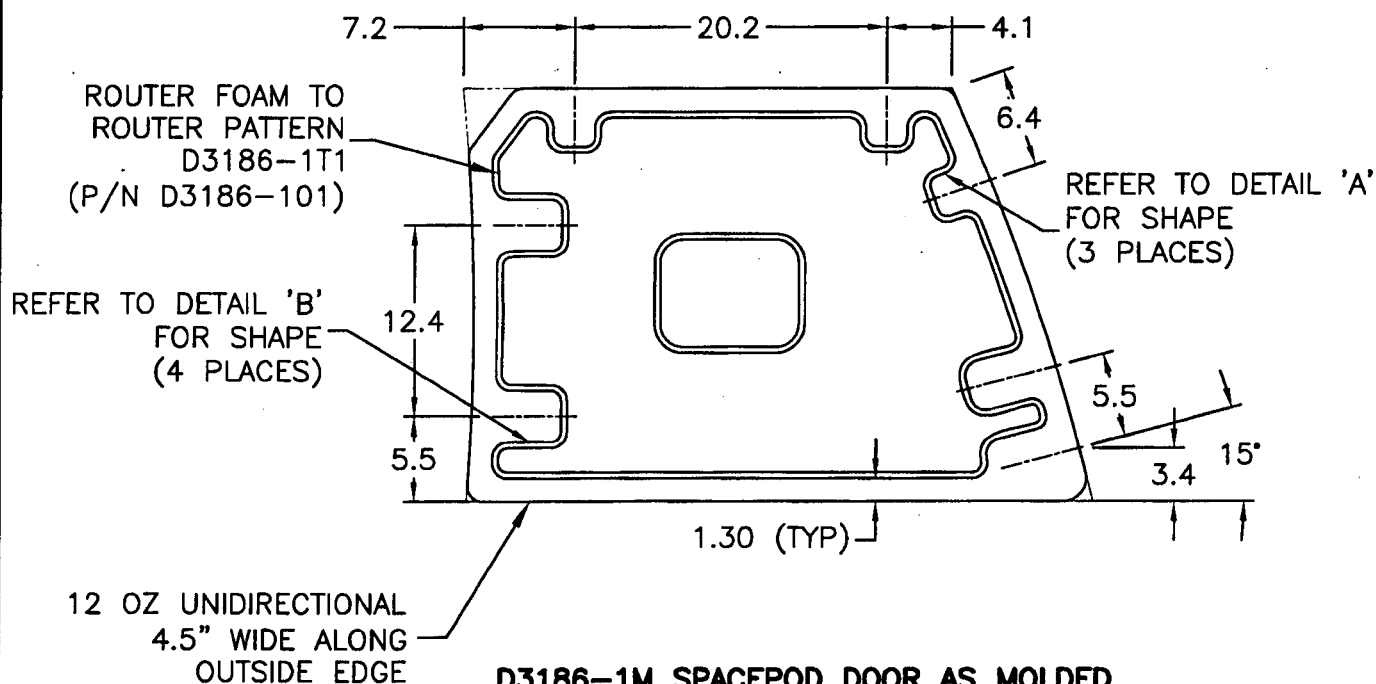
NOTE: Date & initial all entries



DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

#### MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



**D3186-1M SPACEPOD DOOR AS MOLDED**

**RELEASED**  
06.12.22 H

#### NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30085

Copyright © 2003 by DART AEROSPACE LTD

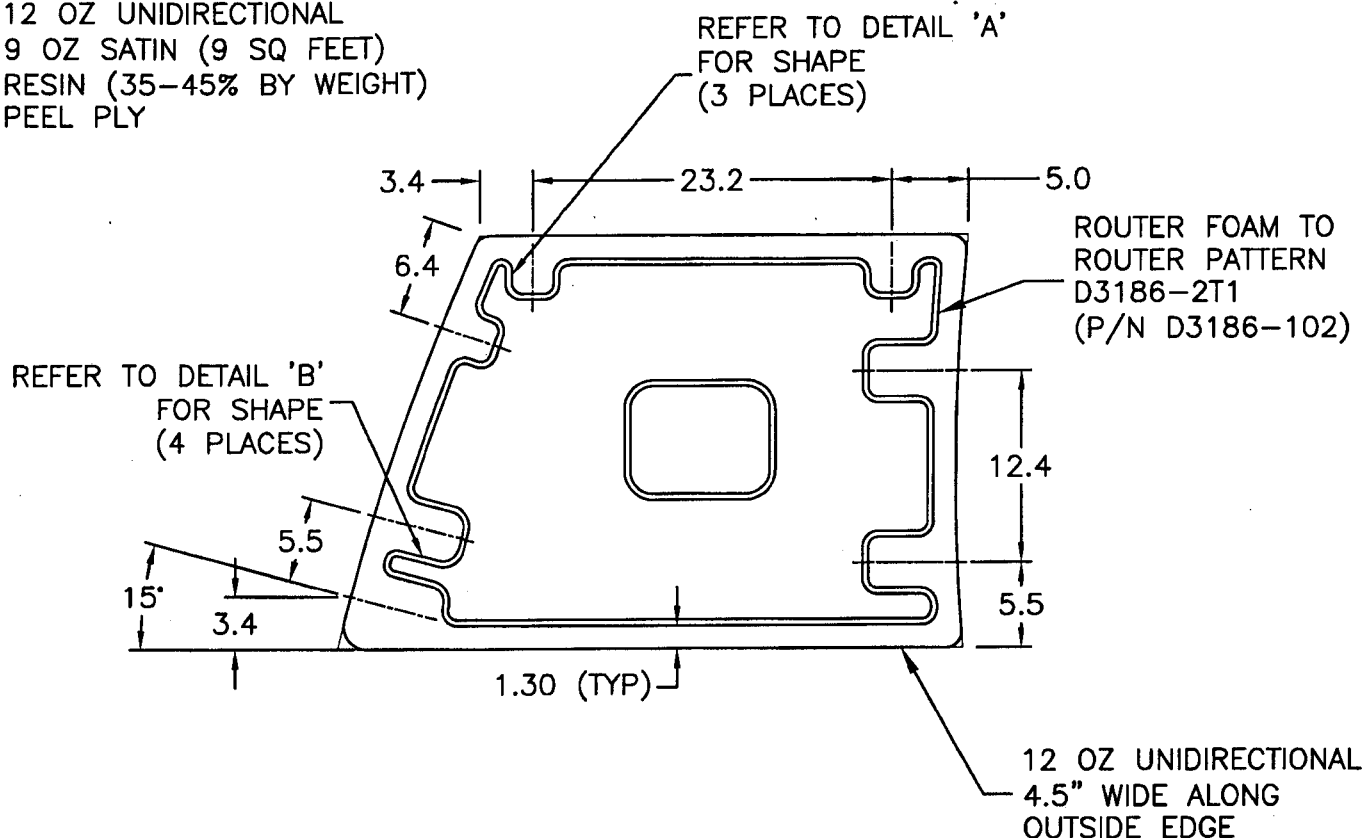
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**  
06.2.22**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30085

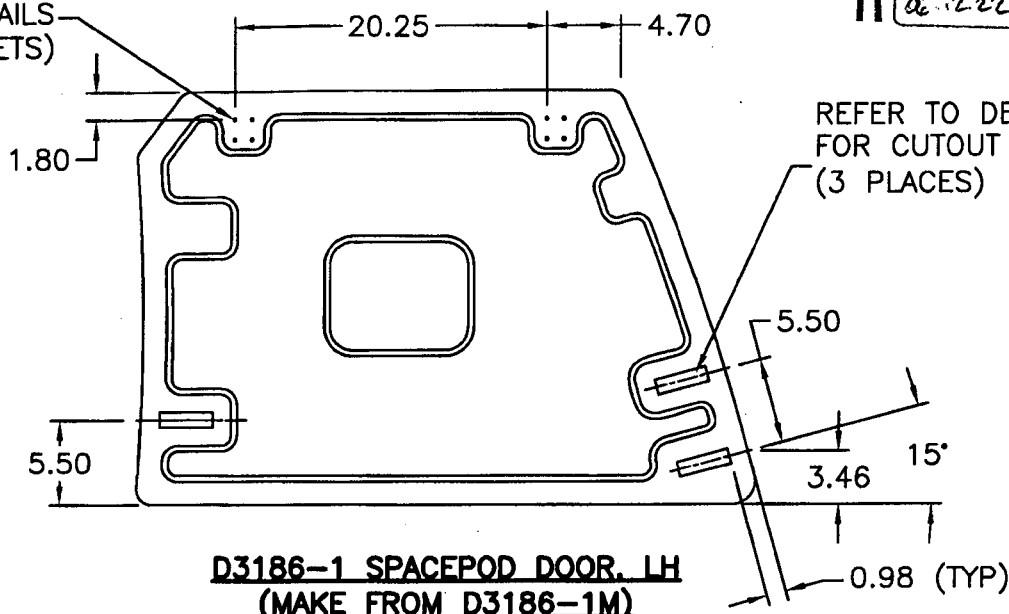
**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



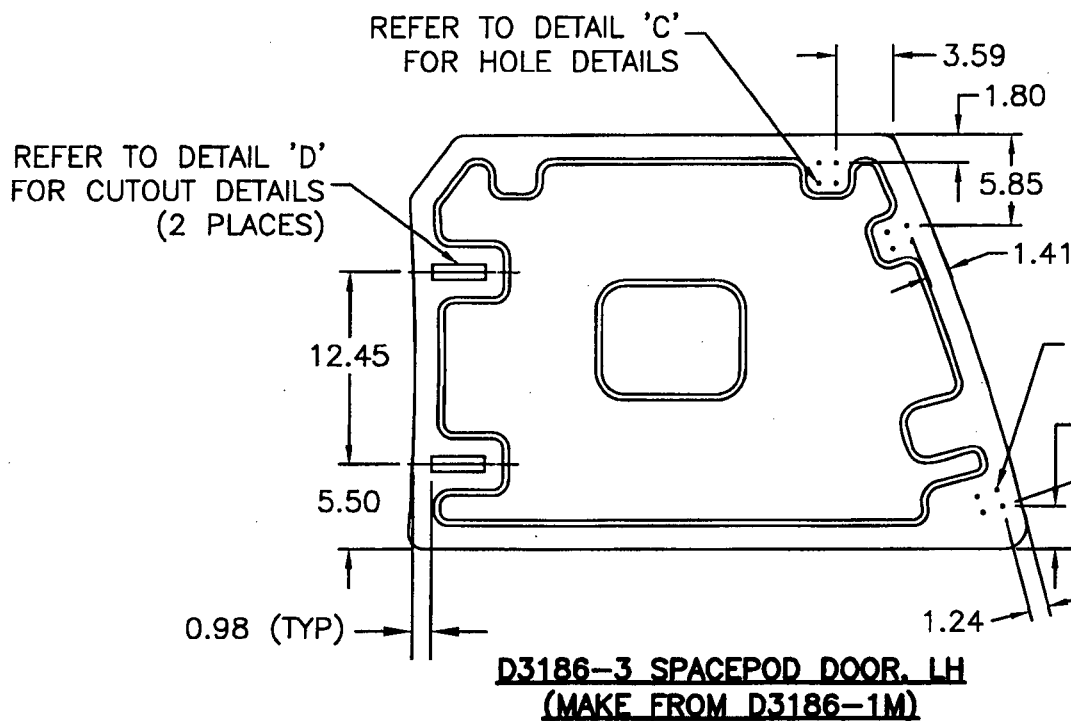
DESIGN DS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. C SHEET 3 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



**RELEASED**  
06-12-22

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(3 PLACES)



**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30085

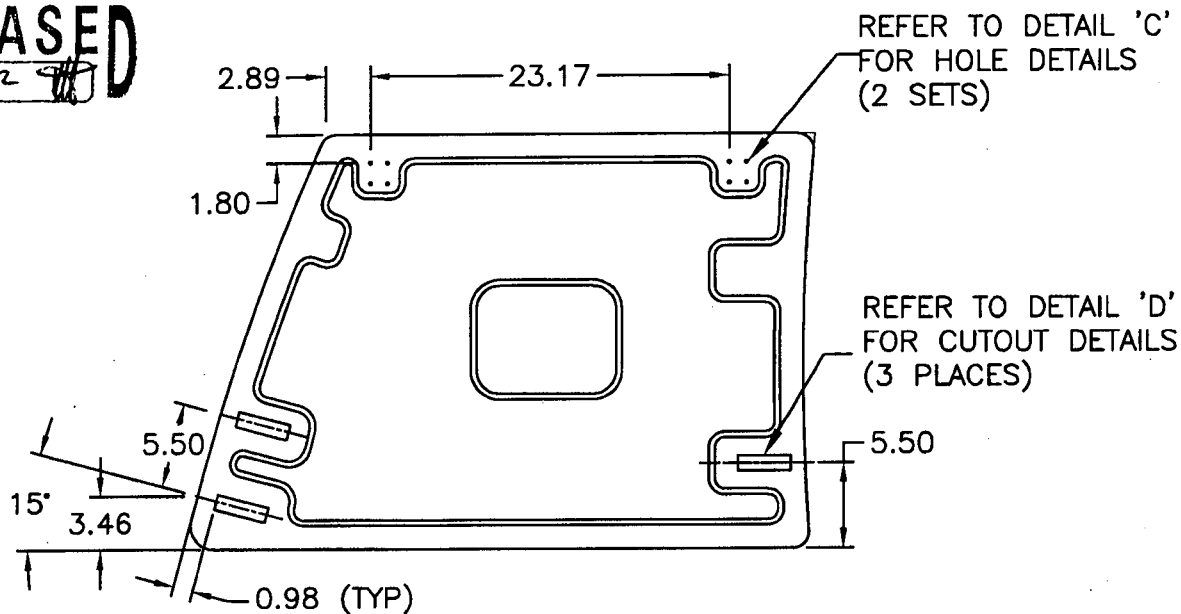
Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

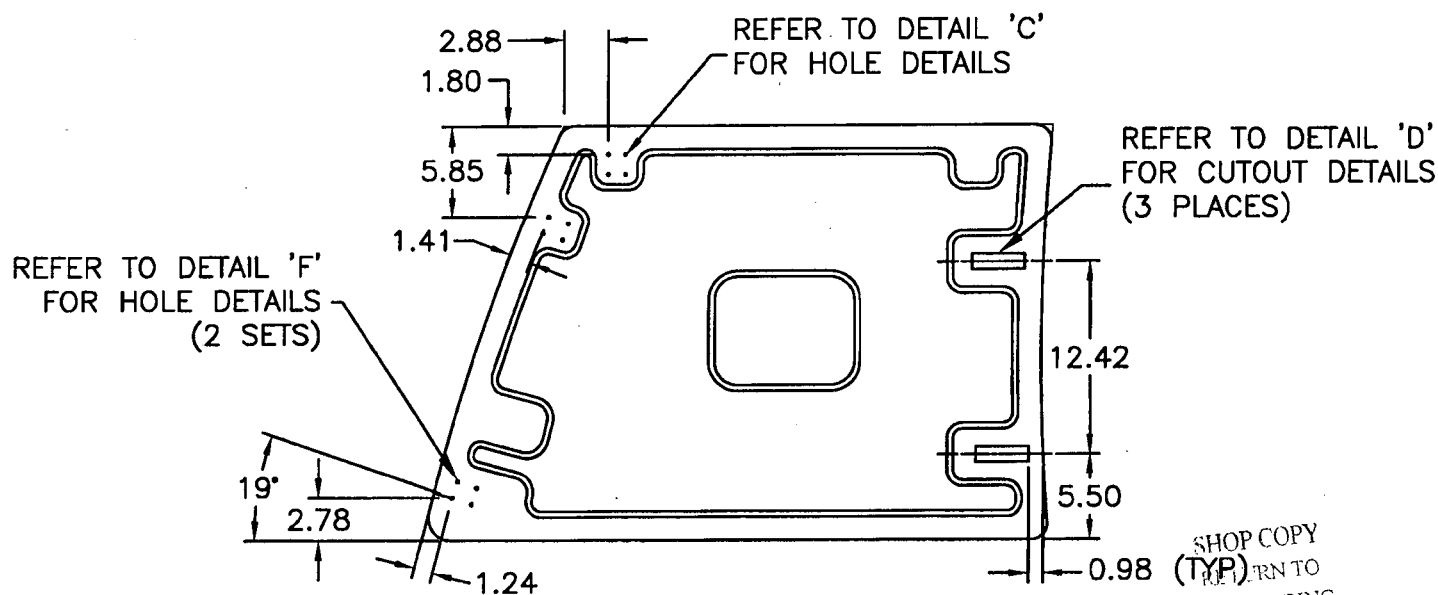


DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 4 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED  
06.12.22



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

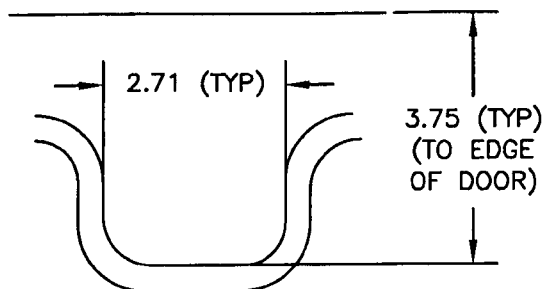
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30085

Copyright © 2003 by DART AEROSPACE LTD

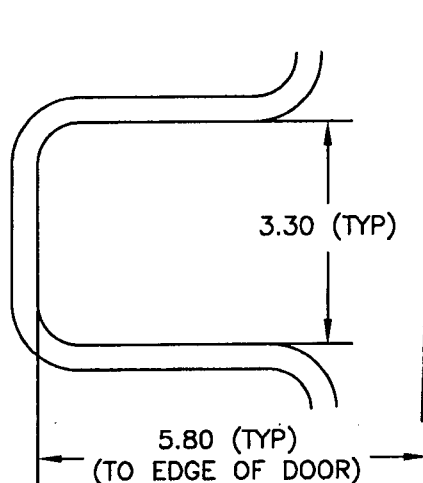
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



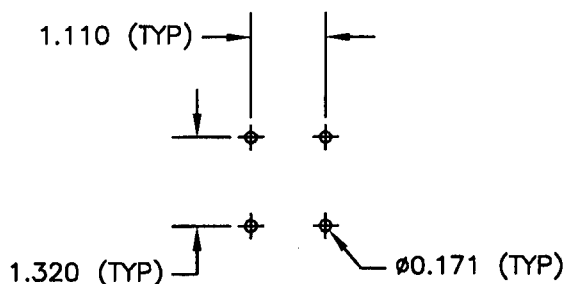
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



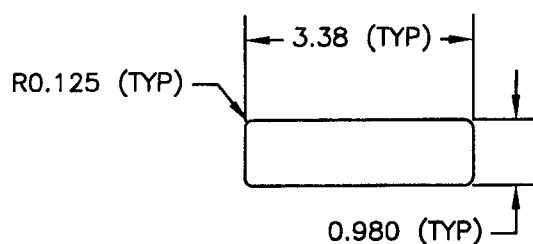
**DETAIL A**



**DETAIL B**

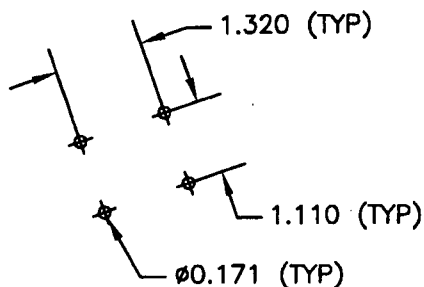


**DETAIL C**

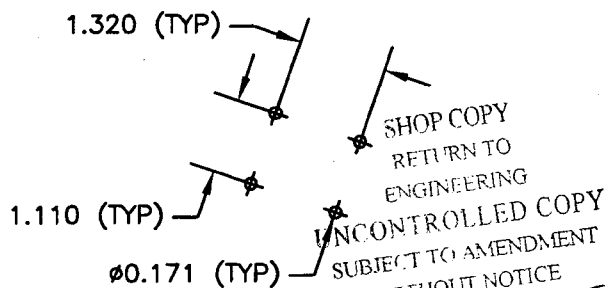


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
30085  
RELEASED  
06.12.22